2006-08 ACCESSORIES & EQUIPMENT

Glass - Civic (All Except Hybrid)

COMPONENT LOCATION INDEX

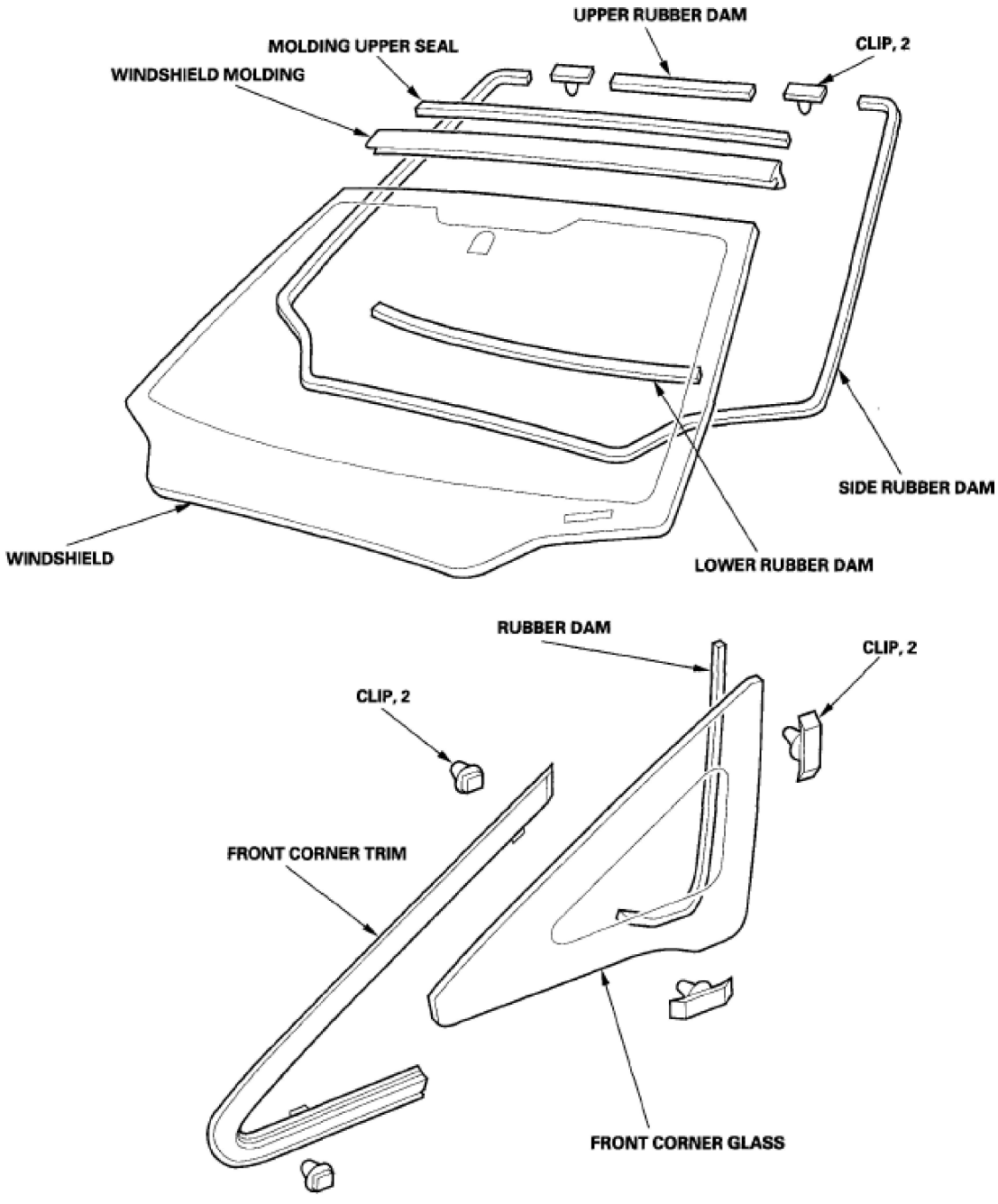

Fig. 1: Exploded View Of Glass

2-door

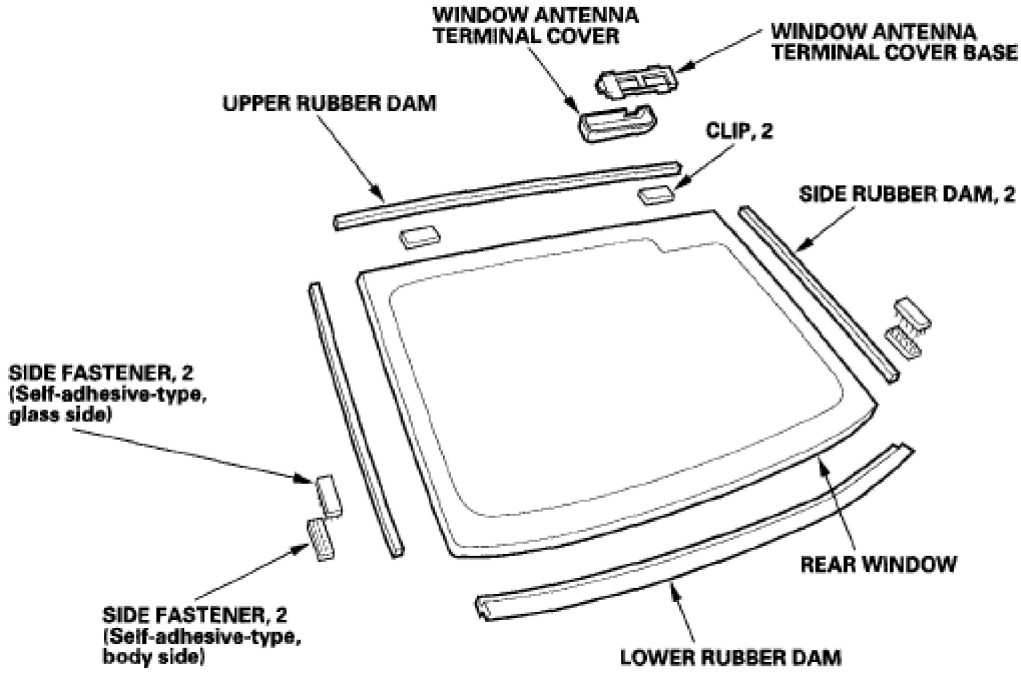

Fig. 2: Exploded View Of Glass (2-Door)

4-door

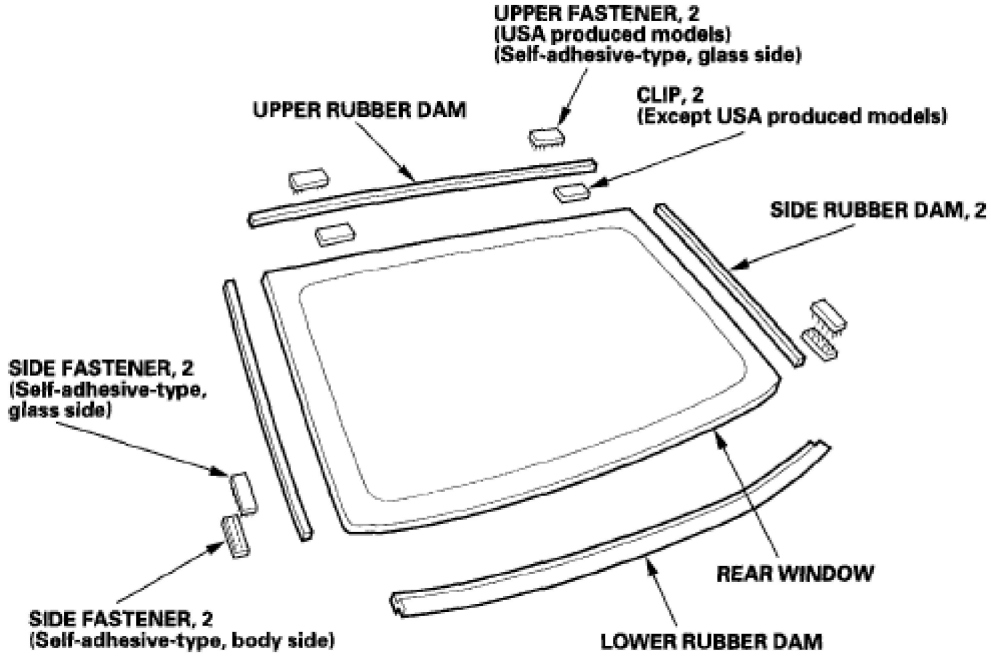
UPPER FASTENER, 2 (USA produced models) (Self-adhesive-type, glass side)
UPPER RUBBER DAM
CLIP, 2 (Except USA produced models)
SIDE RUBBER DAM, 2
SIDE FASTENER, 2 (Self-adhesive-type, glass side)
SIDE FASTENER, 2 (Self-adhesive-type, body side)
REAR WINDOW
LOWER RUBBER DAM

Fig. 3: Exploded View Of Glass (4-Door)

2-door

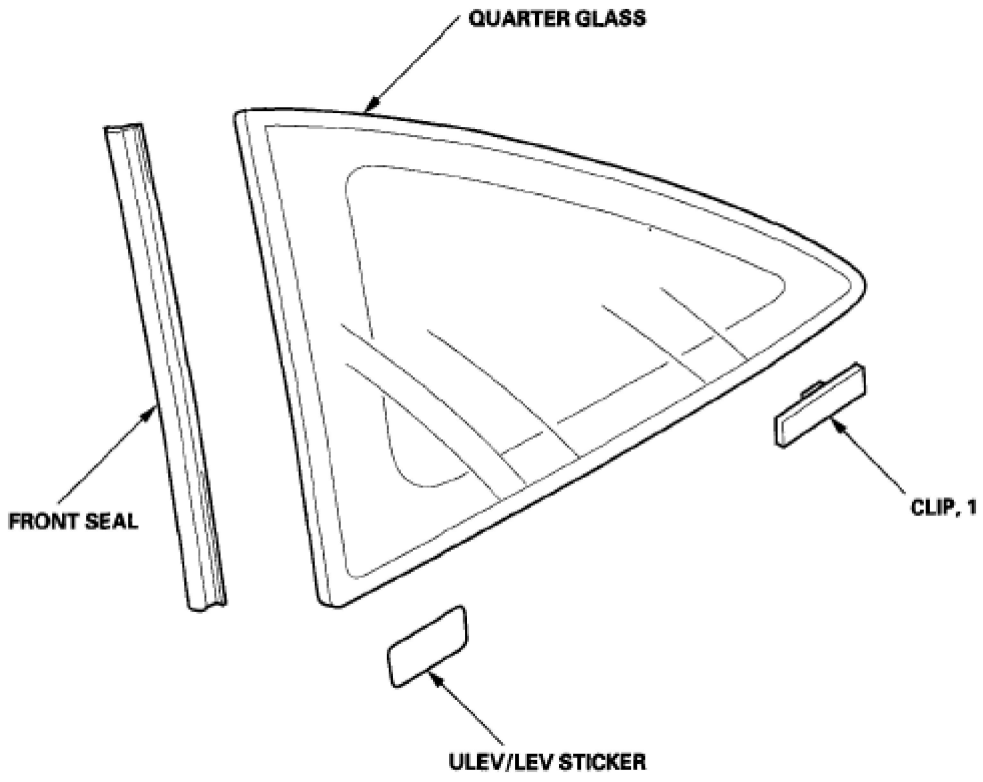

Fig. 4: Exploded View Of Quarter Glass (2-Door)

WINDSHIELD REPLACEMENT

NOTE:

- **Put on gloves to protect your hands.**
- **Wear eye protection while cutting the glass adhesive with a piano wire.**
- **Use seat covers to avoid damaging the seat.**
- **When replacing a broken windshield a commercially available windshield cutter can be efficiently used for cutting the adhesive. For details, follow the instructions of the tool manufacturer.**

1. Remove these items:
   - Windshield wiper arms:

- 2-door (see **2-DOOR**)
- 4-door (see **4-DOOR**)

- Cowl covers (see **COWL COVER REPLACEMENT**)
- Rearview mirror (see **REARVIEW MIRROR REPLACEMENT**)
- A-pillar trim, both sides (see **TRIM REMOVAL/INSTALLATION - PILLAR AREAS**)
- Roof moldings (see **ROOF MOLDING REPLACEMENT**)

2. Remove the molding (A) from the upper edge of the windshield (B). If necessary, cut the molding with a utility knife.

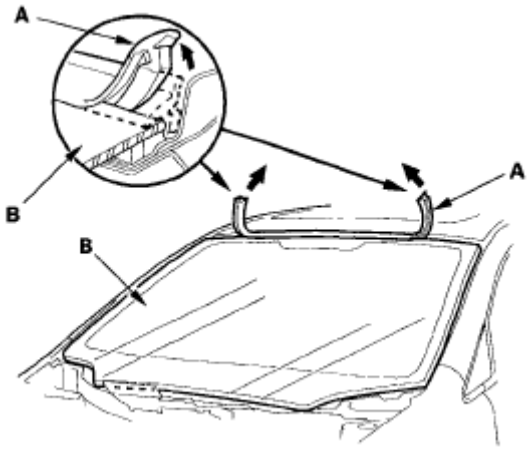

Fig. 5: Removing Molding From Upper Edge Of Windshield

3. If the old windshield will be reinstalled, make alignment marks across the glass and body with a grease pencil.
4. Pull down the front portion of the headliner (see **HEADLINER REMOVAL/INSTALLATION**). Take care not to bend the headliner excessively, or you may crease or break it.
5. Apply protective tape along the edge of the dashboard and body. Using an awl, make a hole through the rubber dam and adhesive from inside the vehicle at the corner portion of the windshield. Push a piece of piano wire through the hole, and wrap each end around a piece of wood.
6. With a helper on the outside, pull the piano wire (A) back and forth in a sawing motion. Hold the piano wire as close to the windshield (B) as possible to prevent damage to the body and dashboard. Carefully cut through the rubber

dam and adhesive (C) around the entire windshield.

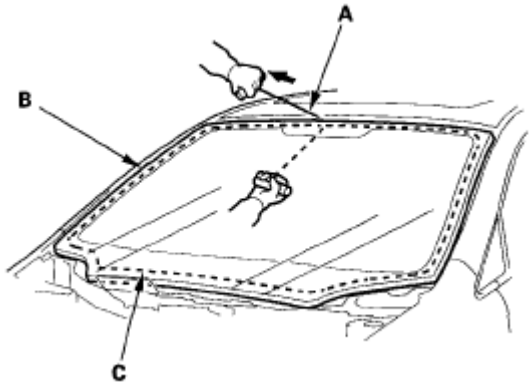

Fig. 6: Cutting Through Rubber Dam And Adhesive Around Windshield

Cutting positions

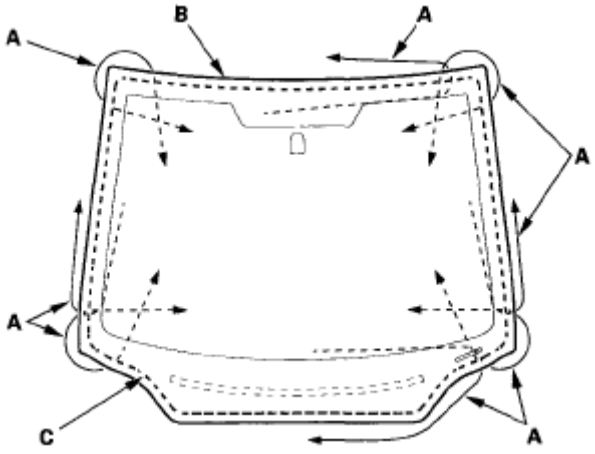

Fig. 7: Identifying Cutting Positions

7. Carefully remove the windshield.
8. With a knife, scrape the old adhesive smooth to a thickness of about 2 mm (0.08 in.) on the bonding surface around the entire windshield opening flange:
   - Do not scrape down to the painted surface of the body; damaged paint will interfere with proper bonding.
   - Remove the rubber dam and fasteners from the body.
   - Replace the dashboard seal with a new one.
9. Clean the body bonding surface with a sponge dampened in alcohol. After

cleaning, keep oil, grease and water from getting on the clean surface.

10. If the old windshield will be reinstalled, use a putty knife to scrape off the old adhesive, the fasteners and the rubber dam from the windshield. Clean the inside face and the edge of the windshield with alcohol where new adhesive will be applied. Make sure the bonding surface is kept free of water, oil, and grease.
11. Attach the upper rubber dam (A), side rubber dam (B), and clips (C) with adhesive tape to the inside face of the windshield (D) as shown in **Fig. 8**:
    - Be sure the rubber dam and clips line up with the alignment marks (E).
    - Be sure the convex portion (F) of the left and right clips toward left.
    - Be careful not to touch the windshield where adhesive will be applied.

Rubber dams adhesive tape:

Thickness 0.16 mm (0.006 in.)
Width 3.5 mm (0.14 in.)

Clips adhesive tape:

Thickness 0.4 mm (0.016 in.)
Width 10 mm (0.39 in.)

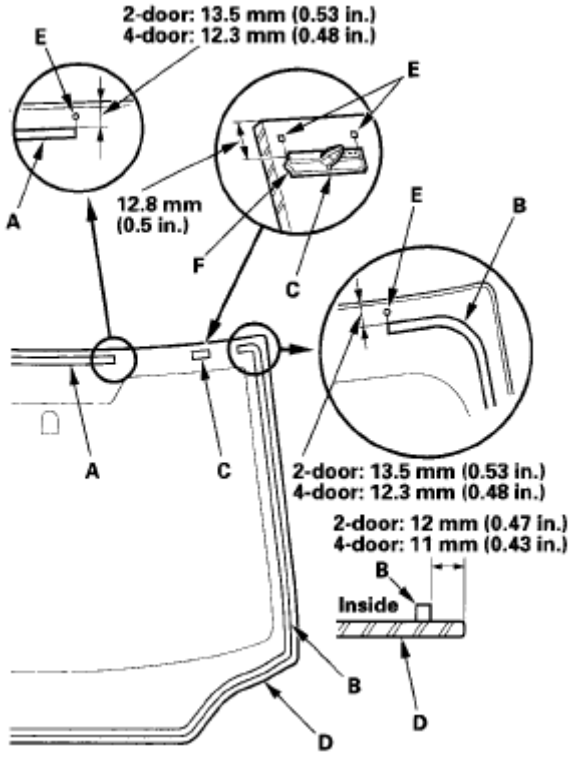

Fig. 8: Attaching Upper Rubber Dam, Side Rubber Dam And Clips With Adhesive Tape To Inside Face Of Windshield (With Specifications)

12. Attach the molding (A) with adhesive tape (B) to the upper edge of the windshield (C). Be careful not to touch the windshield where adhesive will be applied.

    Molding adhesive tape: Thickness 0.8 mm (0.03 in.) Width 4 mm (0.16 in.)

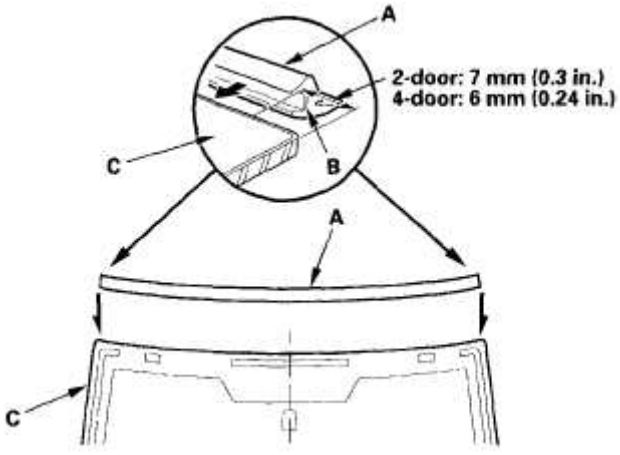

Fig. 9: Attaching Molding With Adhesive Tape To Upper Edge Of Windshield (With Specifications)

13. Apply primer to the molding (A), then attach the molding upper seal (B) with adhesive tape to the inside surface of the molding as shown.

    Seals adhesive tape: Thickness 0.16 mm (0.006 in.) Width 7 mm (0.28 in.)

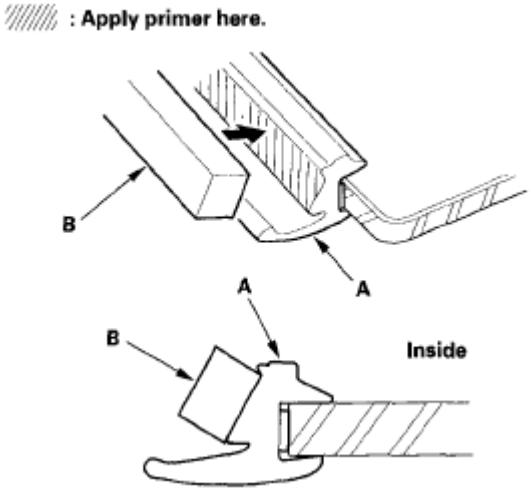

Fig. 10: Applying Primer To Molding

14. Attach the lower rubber dam (A) with body side adhesive tape to the body as shown. Do not peel the glass side adhesive backing.

    Rubber dam adhesive tape:

    Thickness 0.16 mm (0.006 in.)
    Width 5 mm (0.2 in.)

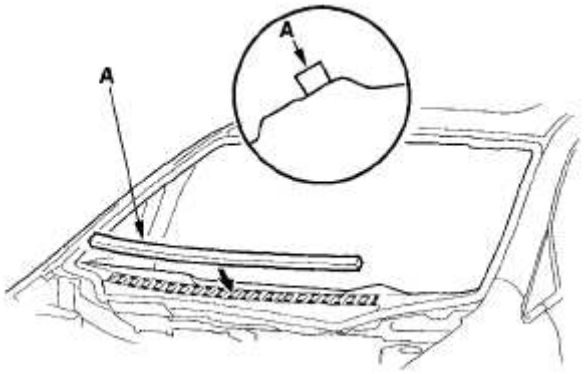

Fig. 11: Attaching Lower Rubber Dam With Body Side Adhesive Tape To Body

15. Set the windshield in the opening, and center it. Make alignment marks (A) across the windshield and body with a grease pencil at the four points shown. Make sure both clips (B) contact with the edge of the body holes. Be careful not to touch the windshield where adhesive will be applied.

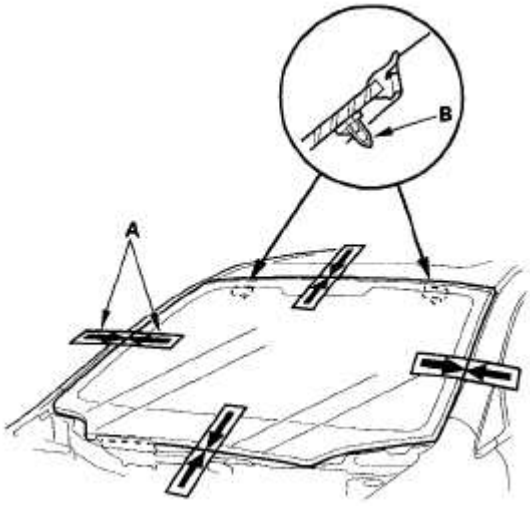

Fig. 12: Making Alignment Marks Across Windshield And Body With Grease Pencil

16. Remove the windshield.
17. With a sponge, apply a light coat of glass primer around the edge of the windshield (A) between the dams (B) and molding (C) as shown, then lightly wipe it off with gauze or cheesecloth:
    - Apply glass primer to the molding.

- Do not apply body primer to the windshield, and do not get body and glass primer sponges mixed up.
- Never touch the primed surfaces with your hands. If you do, the adhesive may not bond to the windshield properly, causing a leak after the windshield is installed.
- Keep water, dust, and abrasive materials away from primed surfaces.

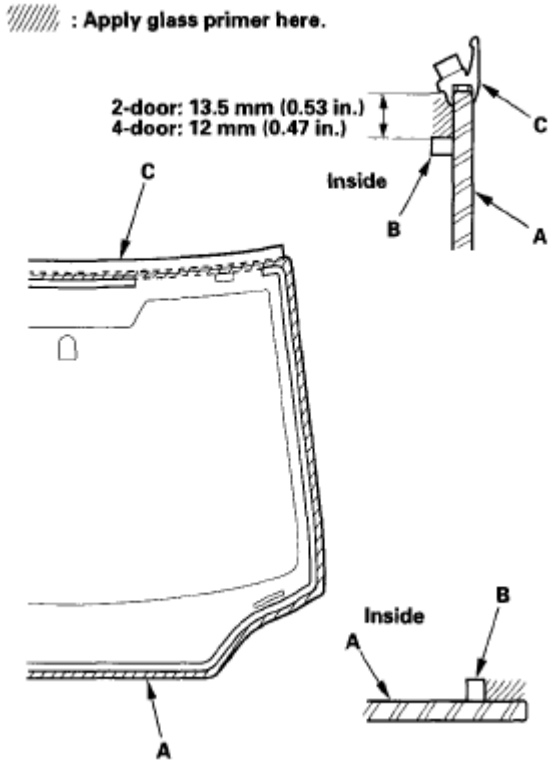

Fig. 13: Applying Glass Primer Around Edge Of Windshield Between Dams And Molding (With Specifications)

18. With a sponge, carefully apply a light coat of body primer to any exposed paint or metal around the flange where new adhesive will be applied. Let the primer dry for at least 10 minutes:
    - Do not apply body primer to any remaining original adhesive on the flange.
    - Be careful not to mix up the body and glass primer sponges.
    - Never touch the primed surfaces with your hands.

Apply body primer to shaded area shown in illustrations.

2-door

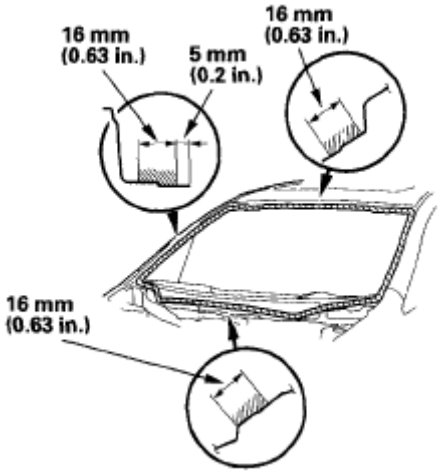

Fig. 14: Applying Body Primer To Exposed Paint (2-Door) (With Specifications)

4-door

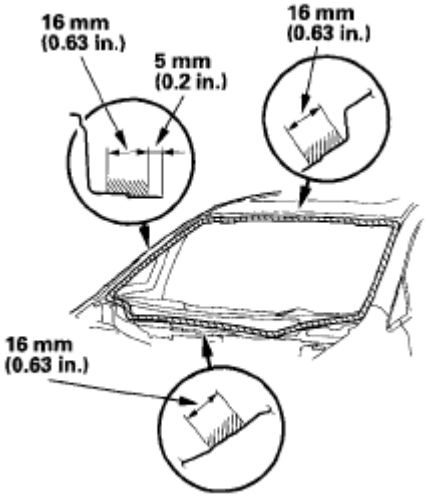

Fig. 15: Applying Body Primer To Exposed Paint (4-Door) (With Specifications)

19. Cut a "V" in the end of the nozzle (A) on the adhesive cartridge as shown.

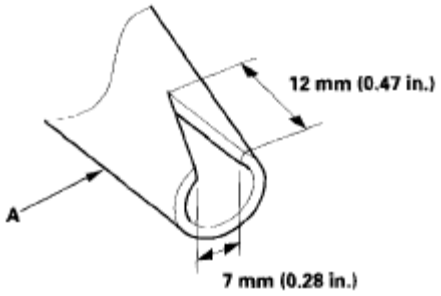

Fig. 16: Cutting "V" In End Of Nozzle (With Specifications)

20. Pack adhesive into the cartridge without air pockets to ensure continuous delivery. Put the cartridge in a caulking gun, and run a bead of adhesive (A) around the edge of the windshield (B) between the dams (C) and molding (D) as shown. Apply the adhesive within 30 minutes after applying the glass primer. Make a slightly thicker bead at each corner.

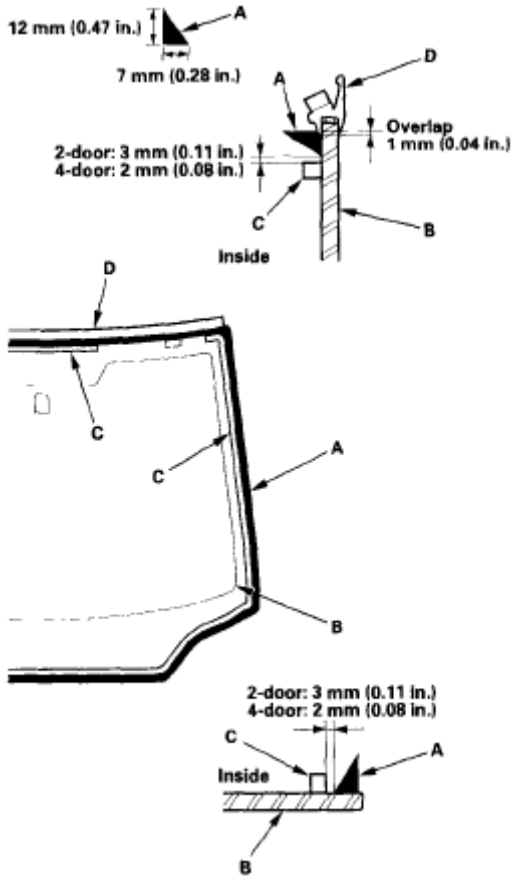

Fig. 17: Running Bead Of Adhesive Around Edge Of Windshield Between Dams And Molding (With Specifications)

21. Pull out the glass side adhesive backing away from the lower rubber dam.
22. Use suction cups to hold the windshield over the opening, align it with the alignment marks made in step 15, and set it down on the adhesive. Lightly push on the windshield until its edges are fully seated on the adhesive all the way around.

NOTE: Do not open or close any of the doors for about an hour until the adhesive is dry.

23. Scrape or wipe the excess adhesive off with a putty knife or towel. To remove adhesive from a painted surface or the windshield, wipe with a soft shop towel dampened with alcohol.
24. After the adhesive has dried, spray water over the windshield and check for leaks. Mark the leaking areas, let the windshield dry, then seal with sealant:
    - Let the vehicle stand for at least 4 hours after windshield installation. If the vehicle has to be used within the first 4 hours, it must be driven slowly.
    - Keep the windshield dry for the first hour after installation.
25. Reinstall all remaining removed parts.

NOTE: Advise the customer not to do the following things for 2 to 3 days:

- **Slam the doors with all the windows rolled up.**
- **Twist the body excessively (such as when going in and out of driveways at an angle or driving over rough, uneven roads).**

FRONT CORNER GLASS REPLACEMENT

4-DOOR

NOTE:

- **Put on gloves to protect your hands.**
- **Wear eye protection while cutting the glass adhesive.**

- **Use seat covers to avoid damaging any surface.**

1. Remove the A-pillar trim (see **TRIM REMOVAL/INSTALLATION - PILLAR AREAS**).
2. From inside the vehicle, use a knife (A) to cut through the front corner glass adhesive (B) all the way around. Apply protective tape along the edge of the entire front corner glass opening flange.

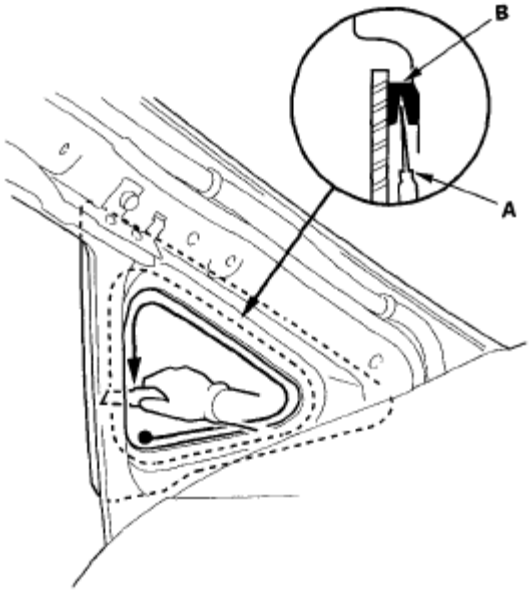

Fig. 18: Cutting Through Front Corner Glass Adhesive Using Knife

3. From outside the vehicle, pry the front corner glass clips (A) and the front corner trim clips (B), then carefully remove the glass (C) and trim (D) together. The trim has not be attached to the glass.

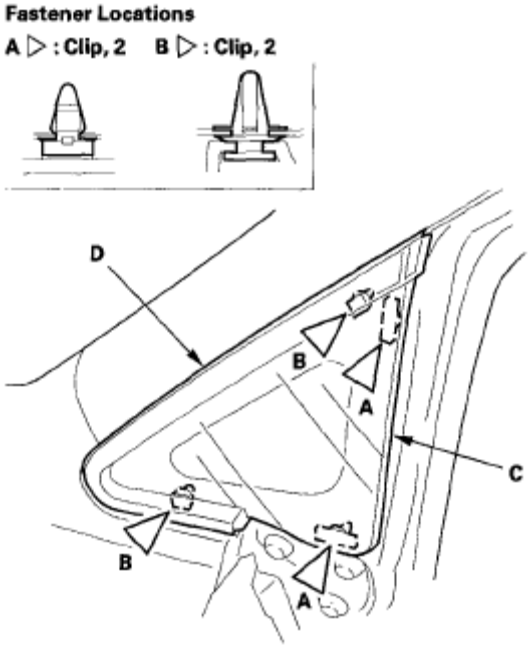

Fig. 19: Prying Front Corner Glass Clips And Trim Clips

4. With a putty knife, scrape the old adhesive smooth to a thickness of about 2 mm (0.08 in.) on the bonding surface around the entire front corner glass opening flange:
   - Do not scrape down to the painted surface of the body; damaged paint will interfere with proper bonding.
   - If any of the clips are broken, remove them from the body.
5. Clean the body bonding surface with a sponge dampened in alcohol. After cleaning, keep oil, grease, and water from getting on the surface.
6. If the old front corner glass will be reinstalled, use a putty knife to scrape off the old adhesive from the front corner glass. Clean the inside face of the front corner glass and the edge of the glass with alcohol where new adhesive will be applied. Make sure the bonding surface is kept free of water, oil, and grease.
7. Attach the rubber dam (A) and clips (B) with adhesive tape to the inside face of the front corner glass (C) as shown in **Fig. 20**.

   Be careful not to touch the front corner glass where adhesive will be applied.

   Rubber dam adhesive tape:

Thickness 0.16 mm (0.006 in.)
Width 3 mm (0.12 in.)

Clip adhesive tape:

Thickness 1.2 mm (0.047 in.)
Width 9 mm (0.35 in.)

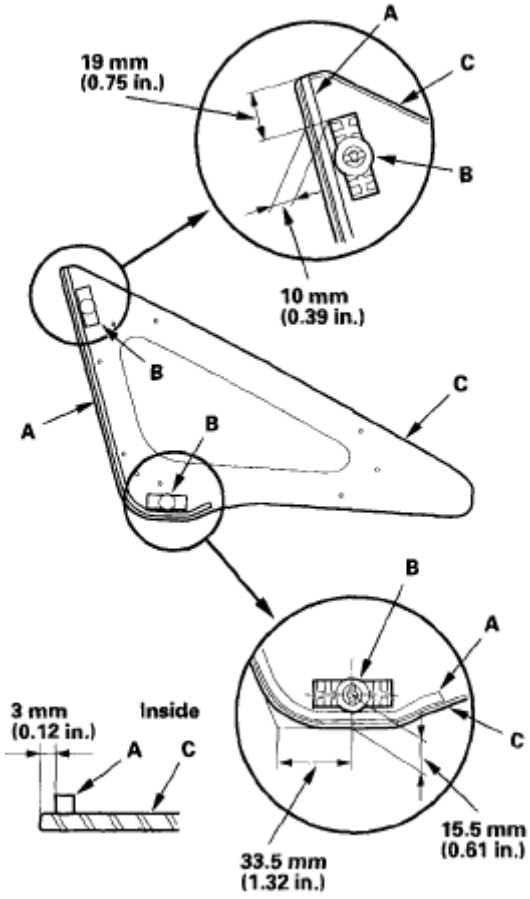

Fig. 20: Attaching Rubber Dam And Clips With Adhesive Tape To Inside Face Of Front Corner Glass (With Specifications)

8. With a sponge, apply a light coat of glass primer to the inside face of the front corner glass (A) as shown in **Fig. 21**, then lightly wipe it off with gauze or cheesecloth:
   - With the printed dots (B) on the front corner glass as a guide, apply the glass primer to both lower corner portions of the front corner glass.

- Do not apply body primer to the front corner glass, and do not get body and glass primer sponges mixed up.
- Never touch the primed surfaces with your hands. If you do the adhesive may not bond to the front corner glass properly, causing a leak after the front corner glass is installed.
- Keep water, dust, and abrasive materials away from primed surface.

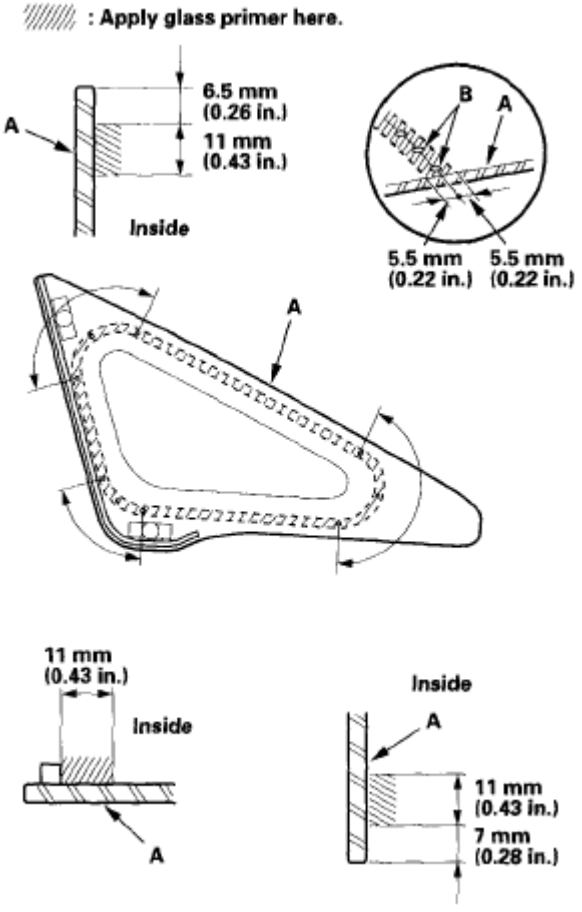

Fig. 21: Applying Glass Primer To Inside Face Of Front Corner Glass (With Specifications)

9. With a sponge, apply a light coat of body primer to the original adhesive remaining around the front corner glass opening flange. Let the body primer dry for at least 10 minutes:
   - Do not apply glass primer to the body, and be careful not to mix up glass and body primer sponges.

- Never touch the primed surfaces with your hands.
- Mask off the dashboard before painting the flange.

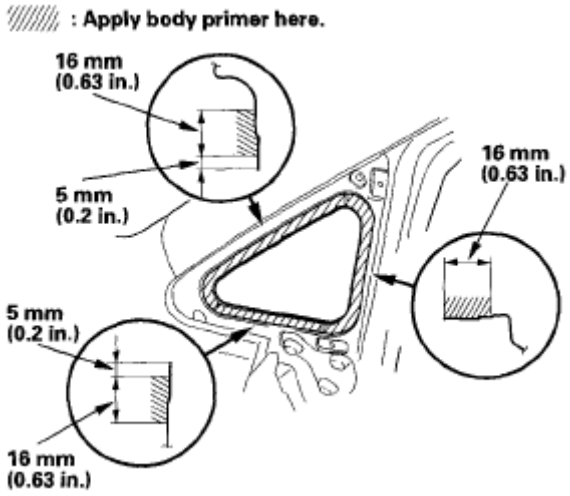

Fig. 22: Applying Body Primer To Original Adhesive Around Front Corner Glass Opening Flange (With Specifications)

10. Before filling a cartridge, cut a "V" in the end of the nozzle (A) as shown.

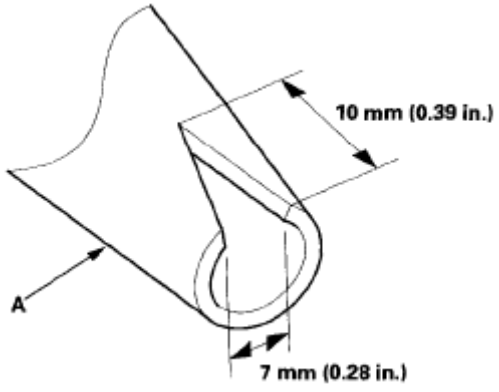

Fig. 23: Cutting "V" In End Of Nozzle (With Specifications)

11. Pack adhesive into the cartridge without air pockets to ensure continuous delivery. Put the cartridge in a caulking gun, and run a bead of adhesive (A) around the front corner glass (B) as shown:
    - With the printed dots (C) on the front corner glass as a guide, apply the adhesive to both side portions of the front corner glass.

- Apply the adhesive within 30 minutes after applying the glass primer. Make a slightly thicker bead at each corner.

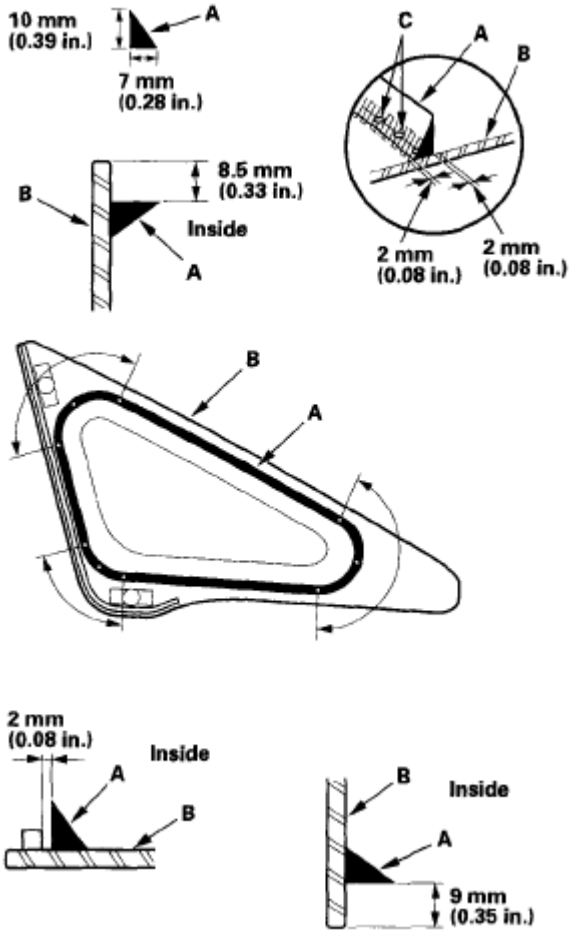

Fig. 24: Running Bead Of Adhesive Around Front Corner Glass (With Specifications)

12. Set the front corner glass (A) to the front corner trim (B) quickly. Be careful not to touch the front corner glass where adhesive will be spread.

NOTE: Make sure that there is no clearance between the sash and front lower sash.

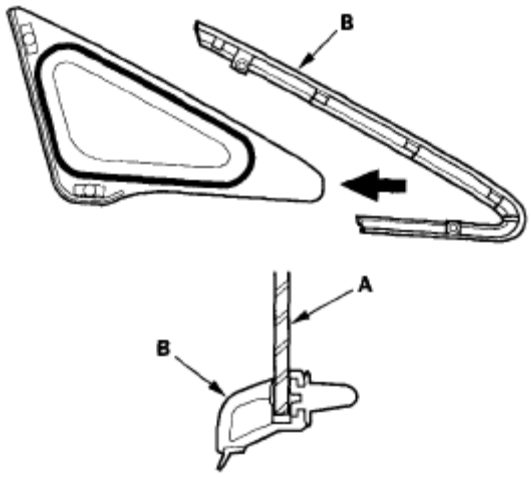

Fig. 25: Setting Front Corner Glass To Front Corner Trim

13. Use a suction cup to hold the front corner glass (A) over the opening while holding the front corner trim (B) by the other hand, align the clips, and set it down on the adhesive. Lightly push on the front corner glass until its edges are fully seated on the adhesive all the way around.

NOTE: Do not open or close any of the doors for about an hour until the adhesive is dry.

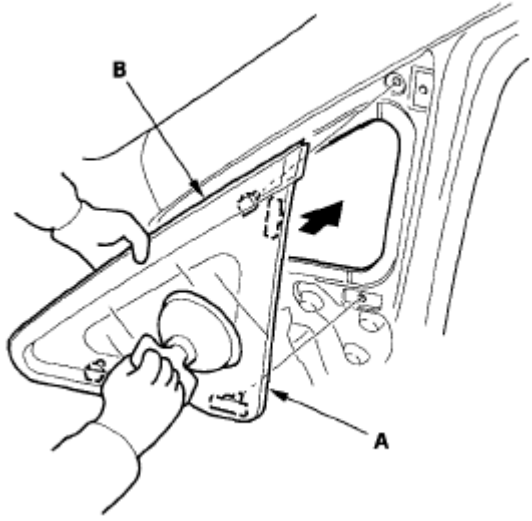

Fig. 26: Using Suction Cup To Hold Front Corner Glass Over Opening

14. Scrape or wipe the excess adhesive off with a putty knife or towel. To remove adhesive from a painted surface or the front corner glass, wipe with a soft shop

towel dampened with alcohol.

15. After the adhesive has dried, spray water over the front corner glass and check for leaks. Mark the leaking areas, let the front corner glass dry, then seal with sealant. Let the vehicle stand for at least 4 hours after front corner glass installation. If the vehicle has to be used within the first 4 hours, it must be driven slowly.
16. Reinstall all remaining removed parts.

NOTE: Advise the customer not to do the following things for 2 to 3 days:

- **Slam the doors with all the windows rolled up.**
- **Twist the body excessively (such as when going in and out of driveways at an angle or driving over rough, uneven roads).**

REAR WINDOW REPLACEMENT

2-DOOR

NOTE:

- **Put on gloves to protect your hands.**
- **Wear eye protection while cutting the glass adhesive with a piano wire.**
- **Use seat covers to avoid damaging any surfaces.**
- **Do not damage the rear window defogger grid lines, window antenna grid lines, and terminals.**

1. Remove these items:
   - Trunk lid
   - Rear shelf (see **TRIM REMOVAL/INSTALLATION - REAR SHELF AREA**)
   - Rear shelf extension (see **REAR SHELF EXTENSION - 2-DOOR**)
   - Quarter pillar trim (see **QUARTER PILLAR TRIM - 2-DOOR**)
2. Remove the window antenna terminal cover (A) from the window antenna

terminal cover base (B), and disconnect the window antenna connector (C).

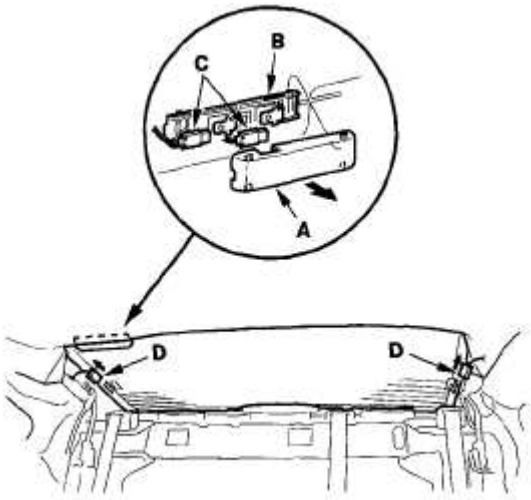

Fig. 27: Removing Terminal Cover From Window Antenna Terminal Cover Base

3. Disconnect the rear window defogger connectors (D).
4. If the old rear window will be reinstalled, make alignment marks across the glass and body with a grease pencil.
5. Pull down the rear portion of the headliner (A) by detaching the clips (B). Take care not to bend the headliner excessively, or you may crease or break it.

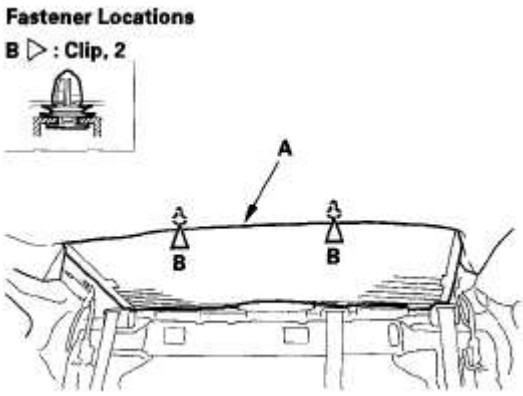

Fig. 28: Detaching Clips To Remove Rear Portion Of Headliner

6. Apply protective tape along the inside and outside edges of the body. Using an awl, make a hole through the adhesive from inside the vehicle at the corner portion of the rear window. Push a piece of piano wire through the hole, and

wrap each end around a piece of wood.

7. Remove the lower rubber dam (A) from the lower edge of the rear window (B). If necessary, cut the molding with a utility knife.

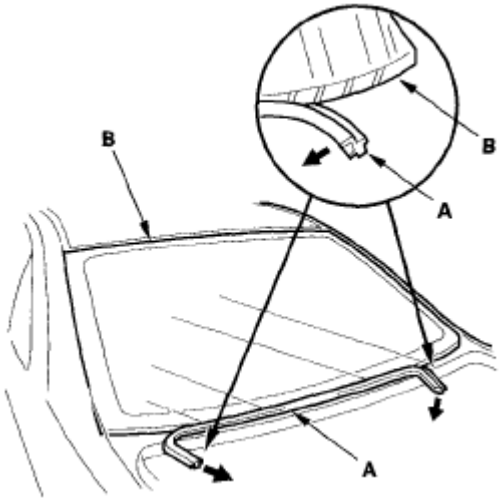

Fig. 29: Removing Lower Rubber Dam From Lower Edge Of Rear Window

8. With a helper on the outside, pull the piano wire (A) back and forth in a sawing motion. Hold the piano wire as close to the rear window (B) as possible to prevent damage to the body, and carefully cut through the adhesive (C) around the entire rear window.

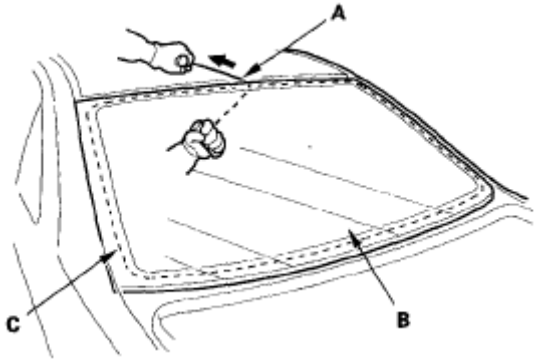

Fig. 30: Pulling Piano Wire Back And Forth In Sawing Motion

Cutting positions

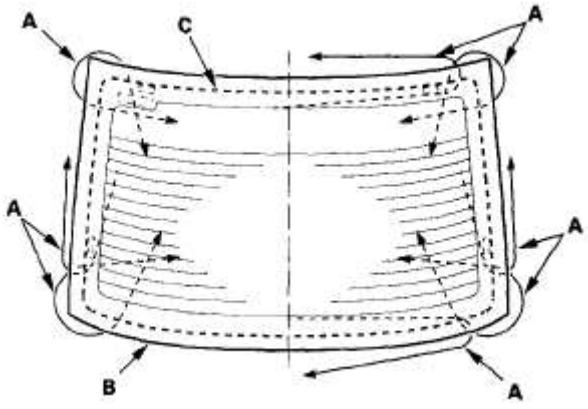

Fig. 31: Identifying Cutting Positions

9. Carefully remove the rear window.
10. With a putty knife, scrape the old adhesive smooth to a thickness of about 2 mm (0.08 in.) on the bonding surface around the entire rear window opening flange:
    - Do not scrape down to the painted surface of the body; damaged paint will interfere with proper bonding.
    - Remove the fasteners from the body.
11. Clean the body bonding surface with a sponge dampened in alcohol. After cleaning, keep oil, grease, and water from getting on the surface.
12. If the old rear window will be reinstalled, use a putty knife to scrape off the old adhesive, the moldings and the fasteners from the rear window. Clean the inside face and the edge of the rear window with alcohol where new adhesive will be applied. Make sure the bonding surface is kept free of water, oil, and grease.
13. Attach the window antenna terminal cover base (A) with adhesive tape to the inside face of the rear window (B) as shown. Apply primer to the inside face of the rear window as shown. Be careful not to touch the rear window where adhesive will be applied.

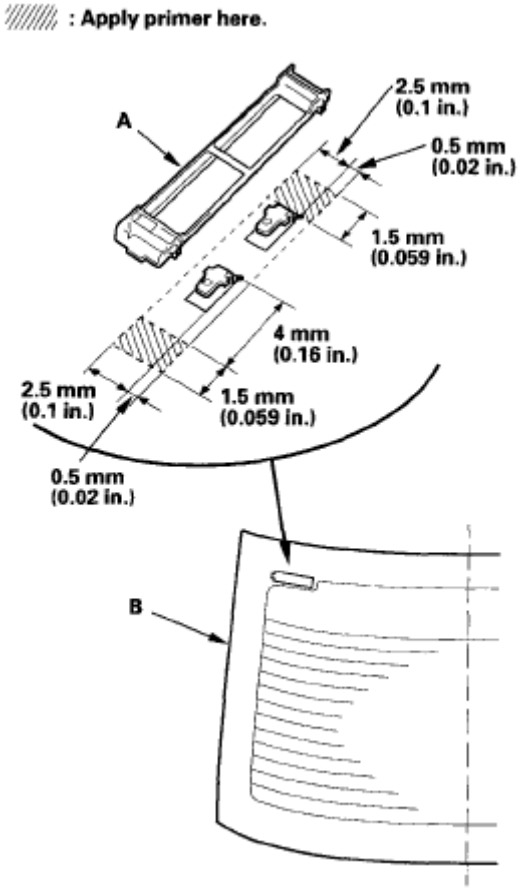

Fig. 32: Identifying Antenna Terminal Cover Base With Adhesive Tape To Inside Face Of Rear Window (With Specifications)

14. Apply primer to the edge of the rear window (A) where the lower rubber dam adhesive tape will be attached as shown. Attach the lower rubber dam (B) with adhesive tape (C) to the lower edge of the rear window:
    - After installing the rubber dam, cut the ends (D) of the rubber dam as shown.
    - Be careful not to touch the windshield where adhesive will be applied.

    Rubber dams adhesive tape:

    Thickness 0.2 mm (0.008 in.)
    Width 4 mm (0.16 in.)

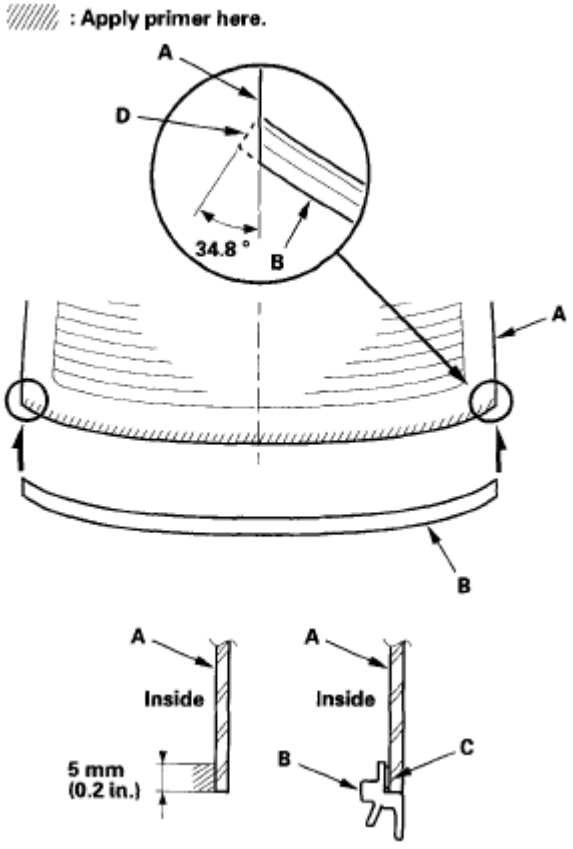

Fig. 33: Applying Primer To Edge Of Rear Window (With Specifications)

15. Attach the upper rubber dams (A), side rubber dam (B), clips (C), and fasteners (D) with adhesive tape to the inside face of the rear window (E) as shown in **Fig. 34**:
    - First attach the upper rubber dam, then attach the side rubber dams around the edge of the rear window. Be sure the top of the side rubber dam contacts with the bottom of the upper rubber dam. If necessary, cut the rubber dam.
    - Be sure the clips, and fasteners line up with the alignment marks (F).
    - Be careful not to touch the rear window where adhesive will be applied.

    Rubber dams adhesive tape:

    Thickness 0.16 mm (0.006 in.)
    Width 4 mm (0.16 in.)

Clips adhesive tape:

Thickness 0.4 mm (0.016 in.)
Width 10 mm (0.39 in.)

Fasteners adhesive tape:

Thickness 0.8 mm (0.03 in.)
Width 7 mm (0.28 in.)

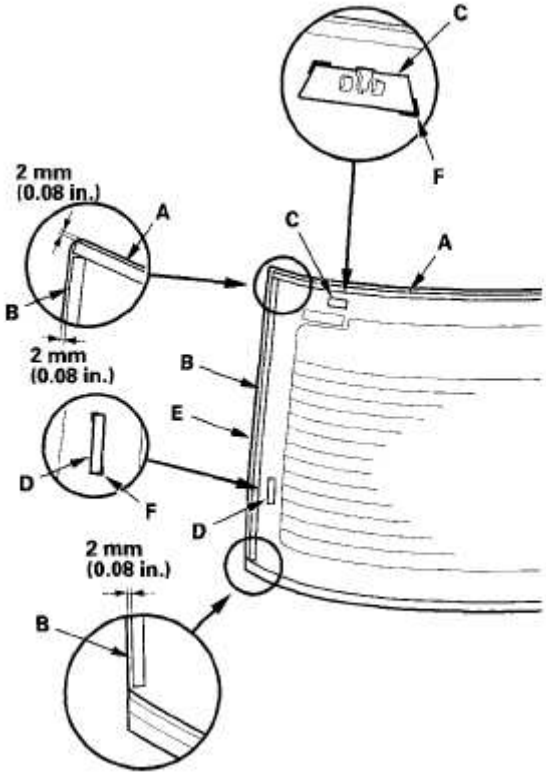

Fig. 34: Attaching Upper Rubber Dams, Side Rubber Dam, Clips And Fasteners With Adhesive Tape To Inside Face Of Rear Window (With Specifications)

16. Attach the fasteners (A) with adhesive tape to the rear window opening flange of the body on both sides.

Fasteners adhesive tape:

Thickness 0.8 mm (0.031 in.)
Width 9 mm (0.35 in.)

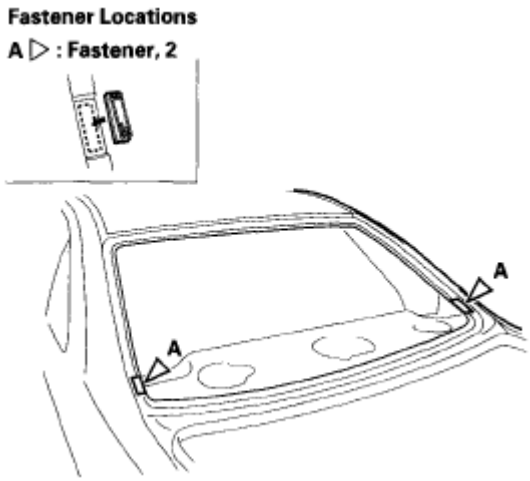

Fig. 35: Attaching Fasteners With Adhesive Tape To Rear Window Opening Flange

17. Set the rear window in the opening, and center it. Make alignment marks (A) across the rear window and body with a grease pencil at the four points shown. Make sure both upper clips (B) are in the body holes. Be careful not to touch the rear window where adhesive will be applied.

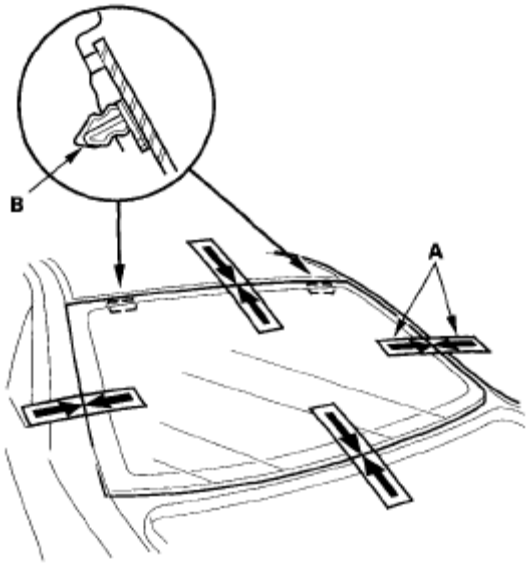

Fig. 36: Making Alignment Marks Across Rear Window And Body

18. Remove the rear window.
19. With a sponge, apply a light coat of glass primer along the edge of the rear window (A) between the dams (B) as shown, then lightly wipe it off with gauze or cheesecloth:
    - Do not apply body primer to the rear window, and do not get body and glass primer sponges mixed up.
    - Never touch the primed surfaces with your hands. If you do, the adhesive may not bond to the rear window properly, causing a leak after the rear window is installed.
    - Keep water, dust, and abrasive materials away from primed surfaces.

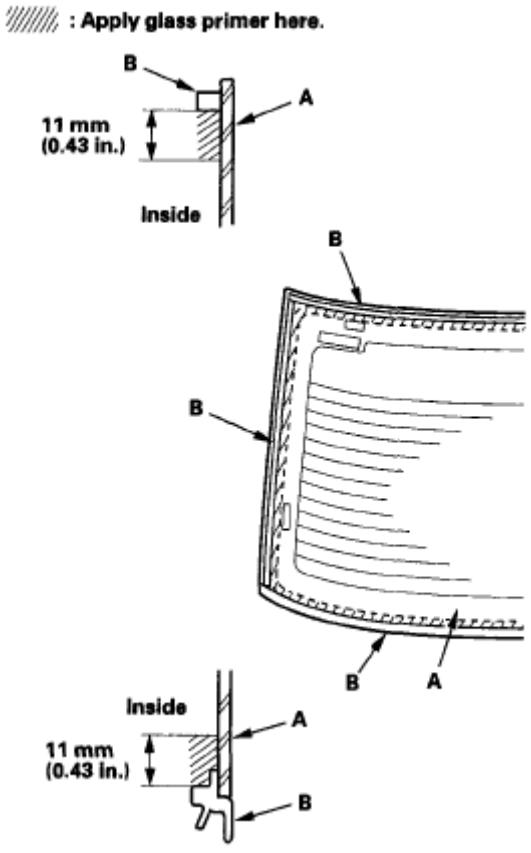

Fig. 37: Applying Glass Primer Along Edge Of Rear Window Between Dams (With Specifications)

20. With a sponge, carefully apply a light coat of body primer to any exposed paint or metal around the flange where new adhesive will be applied. Let the primer

dry for at least 10 minutes:

- Do not apply body primer to any remaining original adhesive on the flange.
- Be careful not to mix up the body and glass primer sponges.
- Never touch the primed surfaces with your hands.

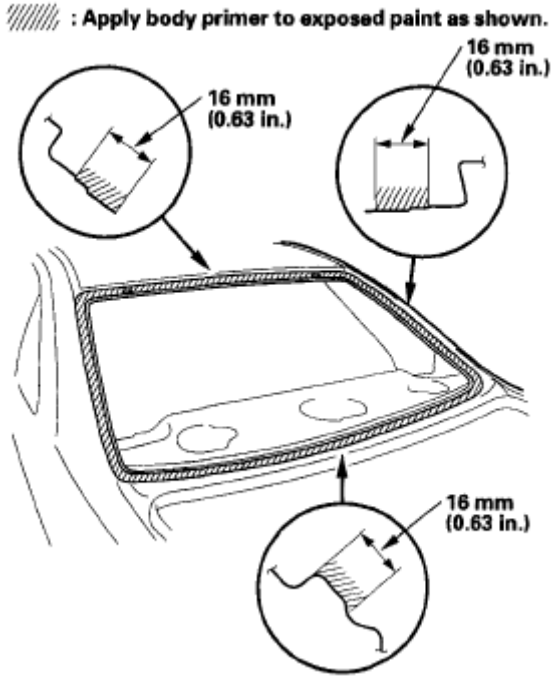

Fig. 38: Applying Body Primer To Any Exposed Paint (With Specifications)

21. Cut a "V" in the end of the nozzle (A) on the adhesive cartridge as shown.

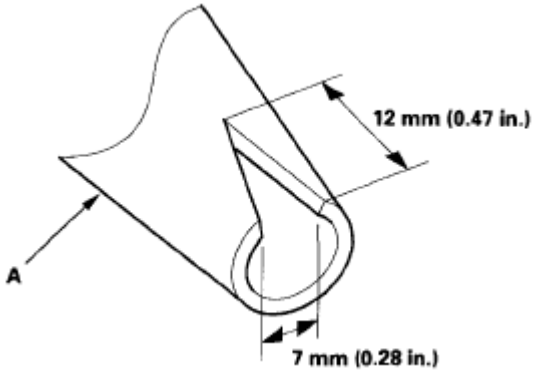

Fig. 39: Cutting "V" In End Of Nozzle (With Specifications)

22. Pack adhesive into the cartridge without air pockets to ensure continuous delivery. Put the cartridge in a caulking gun, and run a bead of adhesive (A) around the edge of the rear window (B) between the dams (C) as shown.

    Apply the adhesive within 30 minutes after applying the glass primer. Make a slightly thicker bead at each corner.

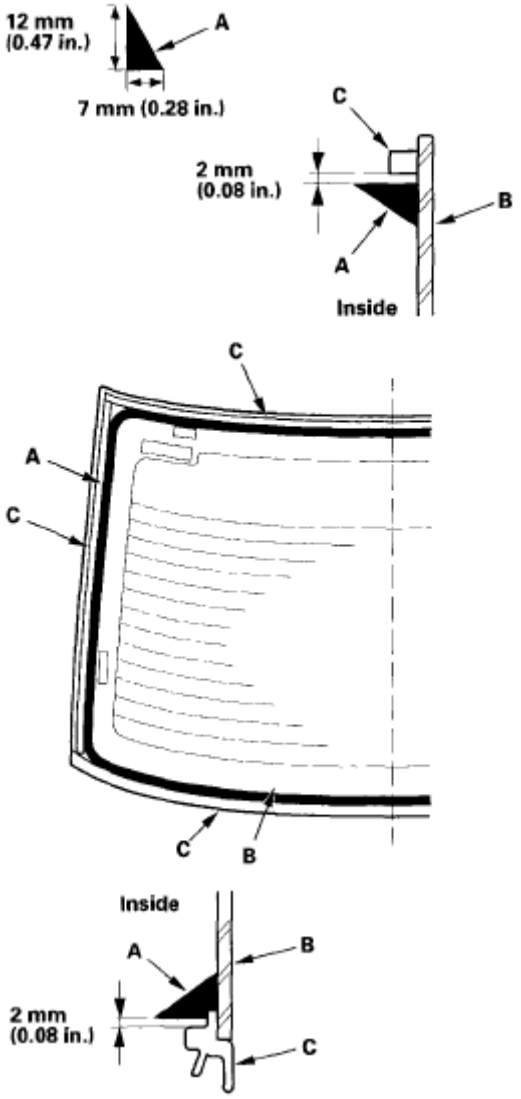

Fig. 40: Running Bead Of Adhesive Around Edge Of Rear Window Between Dams (With Specifications)

23. Use suction cups to hold the rear window over the opening, align it with the alignment marks you made in step 17, and set it down on the adhesive. Lightly

push on the rear window until its edges are fully seated on the adhesive all the way around.

NOTE: Do not open or close any of the doors for about an hour until the adhesive is dry.

24. Scrape or wipe the excess adhesive off with a putty knife or towel. To remove adhesive from a painted surface or the rear window, use a soft shop towel dampened with alcohol.
25. After the adhesive has dried, spray water over the rear window and check for leaks. Mark the leaking areas, let the rear window dry, then seal with sealant. Let the vehicle stand for at least 4 hours after rear window installation. If the vehicle has to be used within the first 4 hours, it must be driven slowly.
26. Reinstall all remaining removed parts.

NOTE: Advise the customer not to do the following things for 2 to 3 days:

- **Slam the doors with all the windows rolled up.**
- **Twist the body excessively (such as when going in and out of driveways at an angle or driving over rough, uneven roads).**

4-DOOR

NOTE:

- **Put on gloves to protect your hands.**
- **Wear eye protection while cutting the glass adhesive with a piano wire.**
- **Use seat covers to avoid damaging any surfaces.**
- **Do not damage the rear window defogger grid lines, window antenna grid lines, and terminals.**

1. Remove these items:
   - Trunk lid

- C-pillar trim (see **C-PILLAR TRIM - 4-DOOR**)
- Rear shelf (see **REAR SHELF EXTENSION - 2-DOOR**)

2. Disconnect the window antenna connectors (A) and rear window defogger connectors (B).

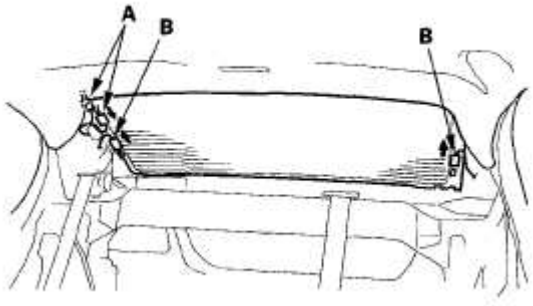

Fig. 41: Disconnecting Window Antenna Connectors And Rear Window Defogger Connectors

3. If the old rear window will be reinstalled, make alignment marks across the glass and body with a grease pencil.
4. Pull down the rear portion of the headliner (A) by detaching the clips (B). Take care not to bend the headliner excessively, or you may crease or break it.

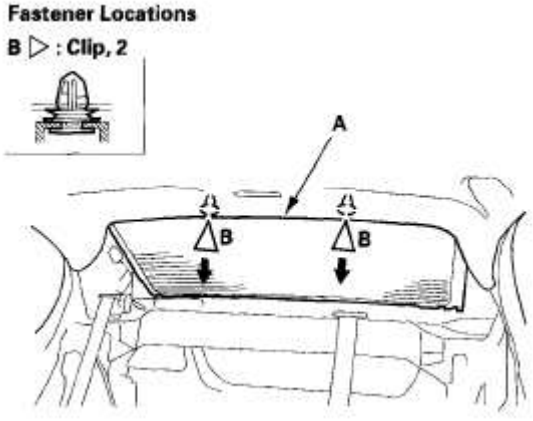

Fig. 42: Detaching Clips To Remove Rear Portion Of Headliner

5. Apply protective tape along the inside and outside edges of the body. Using an awl, make a hole through the adhesive from inside the vehicle at the corner portion of the rear window. Push a piece of piano wire through the hole, and wrap each end around a piece of wood.

6. Remove the lower rubber dam (A) from the lower edge of the rear window (B). If necessary, cut the molding with a utility knife.

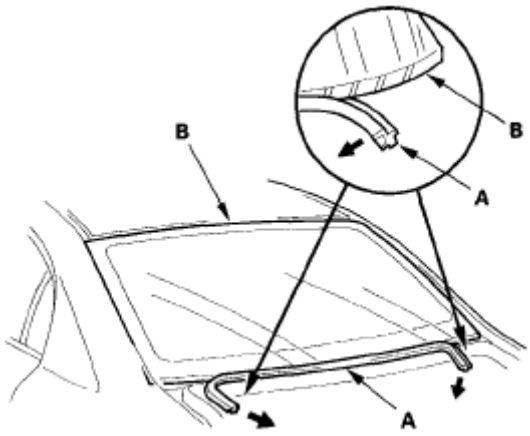

Fig. 43: Removing Lower Rubber Dam From Lower Edge Of Rear Window

7. With a helper on the outside, pull the piano wire (A) back and forth in a sawing motion. Hold the piano wire as close to the rear window (B) as possible to prevent damage to the body, and carefully cut through the adhesive (C) around the entire rear window.

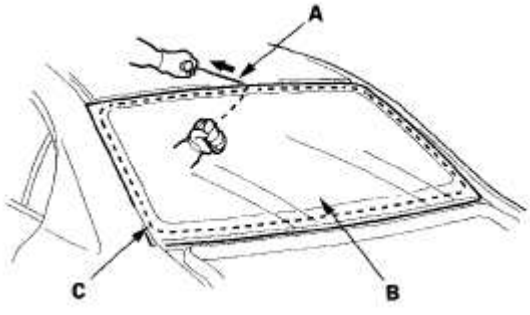

Fig. 44: Pulling Piano Wire Back And Forth In Sawing Motion

Cutting positions

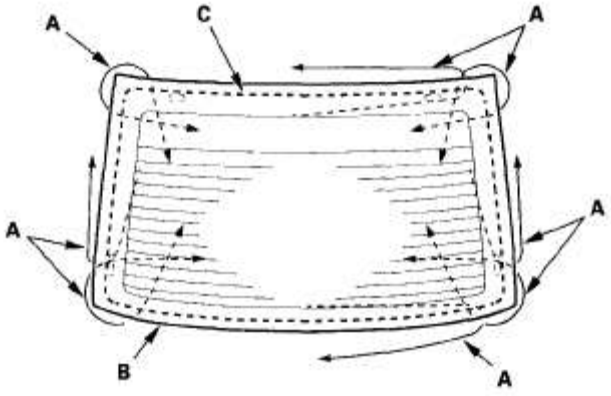

Fig. 45: Identifying Cutting Positions

8. Carefully remove the rear window.
9. With a putty knife, scrape the old adhesive smooth to a thickness of about 2 mm (0.08 in.) on the bonding surface around the entire rear window opening flange:
    - Do not scrape down to the painted surface of the body; damaged paint will interfere with proper bonding.
    - Remove the fasteners from the body.
10. Clean the body bonding surface with a sponge dampened in alcohol. After cleaning, keep oil, grease, and water from getting on the surface.
11. If the old rear window will be reinstalled, use a putty knife to scrape off the old adhesive, the moldings and the fasteners from the rear window. Clean the inside face and the edge of the rear window with alcohol where new adhesive will be applied. Make sure the bonding surface is kept free of water, oil, and grease.
12. Apply primer to the edge of the rear window (A) where the lower rubber dam adhesive tape will be attached as shown. Attach the lower rubber dam (B) with adhesive tape (C) to the lower edge of the rear window:
    - After installing the rubber dam, cut the ends (D) of the rubber dam as shown.
    - Be careful not to touch the windshield where adhesive will be applied.

Molding adhesive tape:

Thickness 0.2 mm (0.008 in.)
Width 4 mm (0.16 in.)

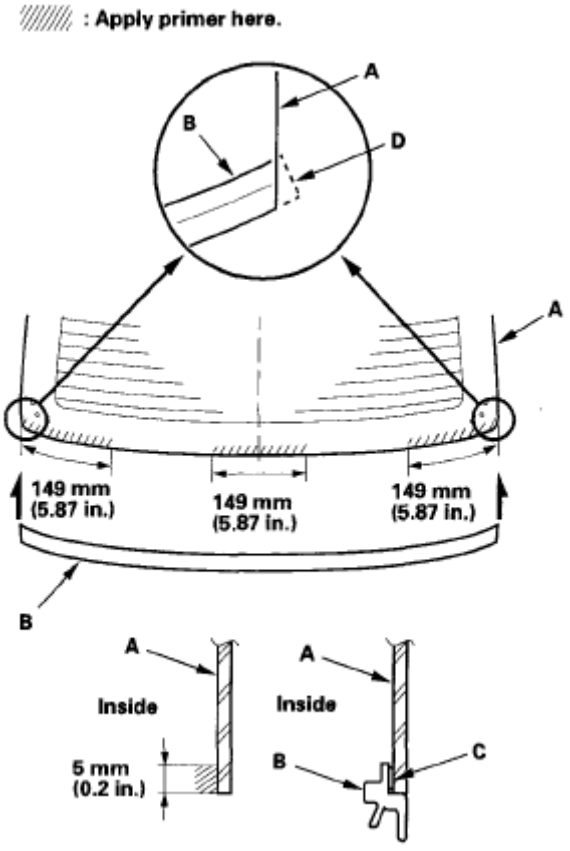

Fig. 46: Applying Primer To Edge Of Rear Window (With Specifications)

13. Attach the upper rubber dams (A), side rubber dams (B), clips (C) (except USA produced models), upper fasteners (D) (USA produced models), and side fasteners (E) with adhesive tape to the inside face of the rear window (F) as shown in **Fig. 47**:
    - First attach the upper rubber dam, then attach the side rubber dams around the edge of the rear window. Be sure the top of the side rubber dam contacts with the bottom of the upper rubber dam. If necessary, cut the rubber dam.
    - Be sure the clips, and fasteners line up with the alignment marks (G).
    - Be careful not to touch the rear window where adhesive will be applied.

Rubber dams adhesive tape:

Thickness 0.16 mm (0.006 in.)
Width 5 mm (0.2 in.)

Clips adhesive tape:

Thickness 0.4 mm (0.016 in.)
Width 13 mm (0.51 in.)

Upper fasteners adhesive tape:

Thickness 0.4 mm (0.016 in.)
Width 11.4 mm (0.45 in.)

Side fasteners adhesive tape:

Thickness 0.8 mm (0.03 in.)
Width 7 mm (0.28 in.)

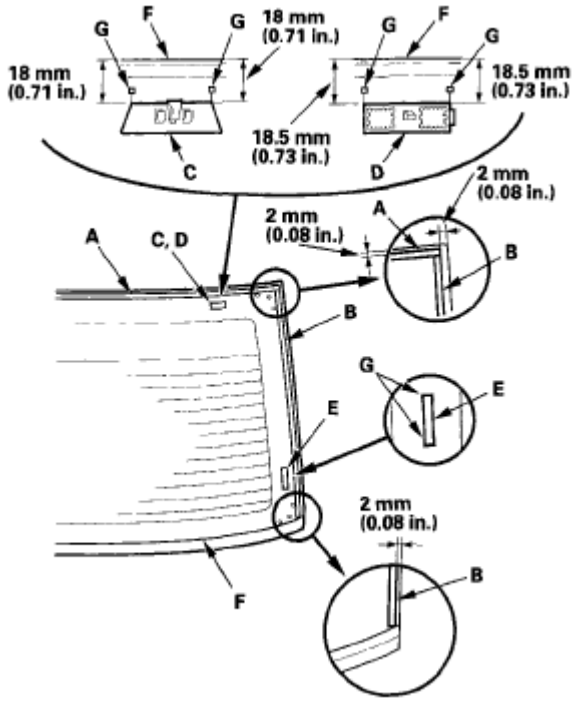

Fig. 47: Attaching Upper Rubber Dams, Side Rubber Dams And Clips (With Specifications)

14. Attach the fasteners (A) with adhesive tape to the rear window opening flange of the body on both sides.

    Fasteners adhesive tape:

    Thickness 0.8 mm (0.031 in.)
    Width 9 mm (0.35 in.)

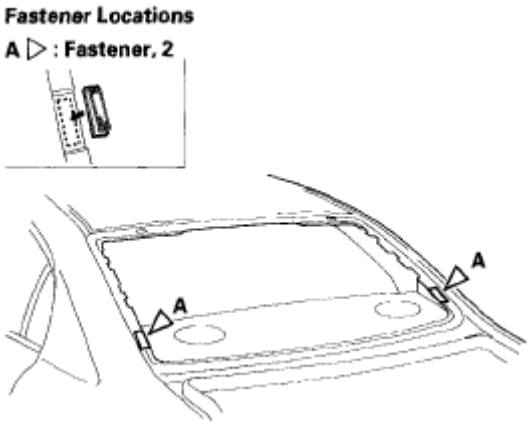

Fig. 48: Attaching Fasteners With Adhesive Tape To Rear Window Opening Flange

15. Set the rear window in the opening, and center it. Make alignment marks (A) across the rear window and body with a grease pencil at the four points shown. Make sure both clips (B) are in the body holes (except USA produced models).

    Make sure both pins (C) from the upper fasteners (D) contact with the edge of the body holes (USA produced models). Be careful not to touch the rear window where adhesive will be applied.

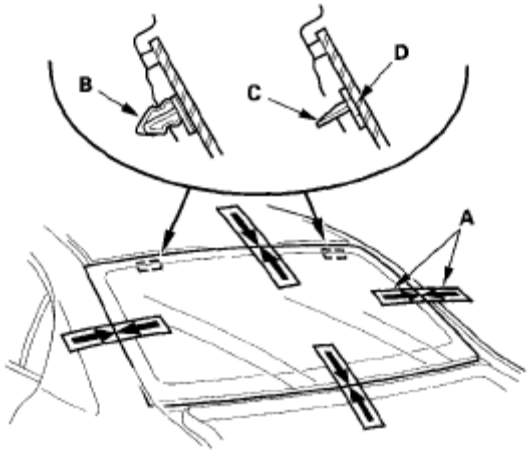

Fig. 49: Making Alignment Marks Across Rear Window And Body

16. Remove the rear window.
17. With a sponge, apply a light coat of glass primer along the edge of the rear window (A) between the dams (B) as shown, then lightly wipe it off with gauze or cheesecloth:
    - With the printed dots (D) on the rear window as a guide, apply the glass primer to both lower corner portions of the rear window.
    - Do not apply body primer to the rear window, and do not get body and glass primer sponges mixed up.
    - Never touch the primed surfaces with your hands. If you do, the adhesive may not bond to the rear window properly, causing a leak after the rear window is installed.
    - Keep water, dust, and abrasive materials away from primed surfaces.

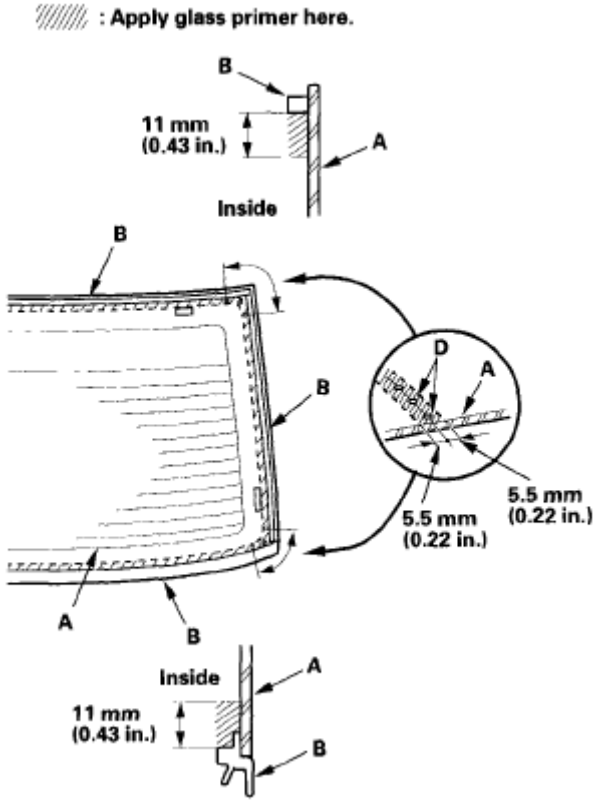

Fig. 50: Applying Glass Primer Along Edge Of Rear Window Between Dams (With Specifications)

18. With a sponge, carefully apply a light coat of body primer to any exposed paint or metal around the flange where new adhesive will be applied. Let the primer dry for at least 10 minutes:
    - Do not apply body primer to any remaining original adhesive on the flange.
    - Be careful not to mix up the body and glass primer sponges.
    - Never touch the primed surfaces with your hands.

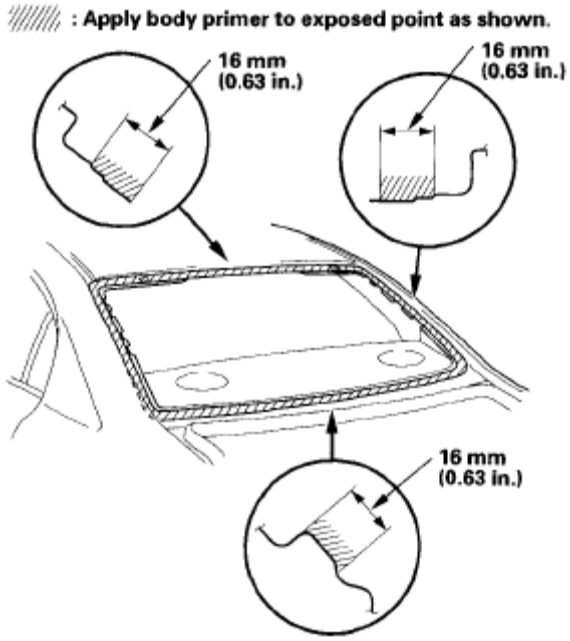

Fig. 51: Applying Body Primer To Any Exposed Paint (With Specifications)

19. Cut a "V" in the end of the nozzle (A) on the adhesive cartridge as shown.

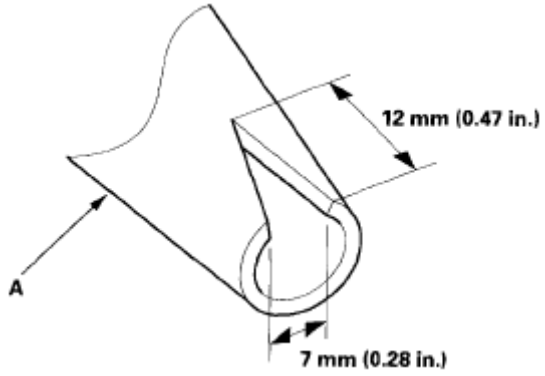

Fig. 52: Cutting "V" In End Of Nozzle (With Specifications)

20. Pack adhesive into the cartridge without air pockets to ensure continuous delivery. Put the cartridge in a caulking gun, and run a bead of adhesive (A) around the edge of the rear window (B) between the dams (C) as shown:
    - With the printed dots (D) on the rear window as a guide, apply the adhesive to both side portions of the rear window.
    - Apply the adhesive within 30 minutes after applying the glass primer.

Make a slightly thicker bead at each corner.

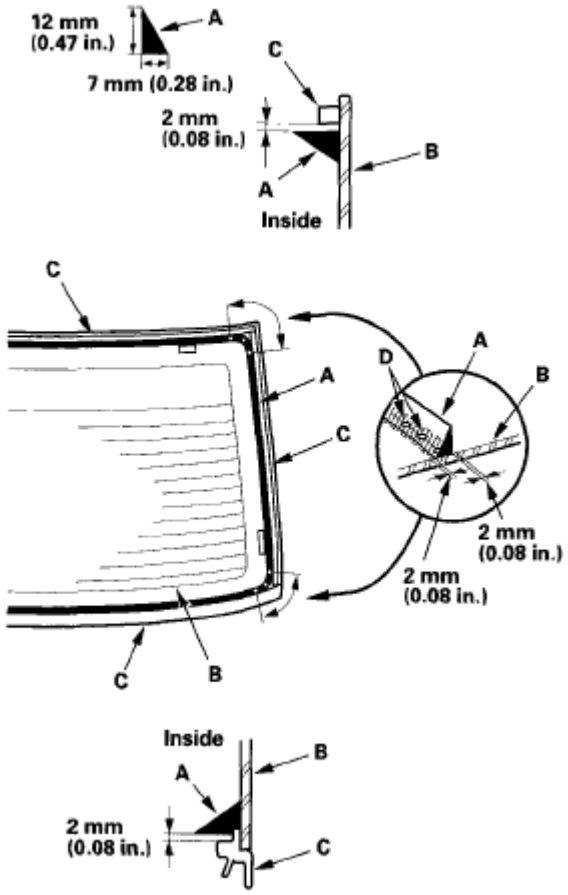

Fig. 53: Running Bead Of Adhesive Around Edge Of Rear Window Between Dams (With Specifications)

21. Use suction cups to hold the rear window over the opening, align it with the alignment marks you made in step 15, and set it down on the adhesive. Lightly push on the rear window until its edges are fully seated on the adhesive all the way around.

NOTE: Do not open or close any of the doors for about an hour until the adhesive is dry.

22. Scrape or wipe the excess adhesive off with a putty knife or towel. To remove adhesive from a painted surface or the rear window, use a soft shop towel dampened with alcohol.

23. After the adhesive has dried, spray water over the rear window and check for leaks. Mark the leaking areas, let the rear window dry, then seal with sealant. Let the vehicle stand for at least 4 hours after rear window installation. If the vehicle has to be used within the first 4 hours, it must be driven slowly.
24. Reinstall all remaining removed parts.

NOTE: Advise the customer not to do the following things for 2 to 3 days:

- **Slam the doors with all the windows rolled up.**
- **Twist the body excessively (such as when going in and out of driveways at an angle or driving over rough, uneven roads).**

QUARTER GLASS REPLACEMENT

2-DOOR

NOTE:

- **Put on gloves to protect your hands.**
- **Use seat covers to avoid damaging any surface.**

1. Remove these items:
   - Rear seat cushion (see **SEAT CUSHION**)
   - Rear shelf (see **TRIM REMOVAL/INSTALLATION - REAR SHELF AREA**)
   - Rear shelf extension (see **REAR SHELF EXTENSION - 2-DOOR**)
   - Rear side trim panel, as needed (see **2-DOOR**)
   - Front seat belt upper anchor (see step 7 in **FRONT SEAT BELT - 2-DOOR**)
   - Quarter pillar trim (see **QUARTER PILLAR TRIM - 2-DOOR**)
2. Apply protective tape along the inside and outside edges of the body, and along the edge of the headliner. Using an awl, make a hole through the adhesive from inside the vehicle. Push a piece of piano wire through the hole, and wrap each end around a piece of wood.

3. Remove the front seal (A) from the front edge of the quarter glass (B). If necessary, cut the front seal with a utility knife.

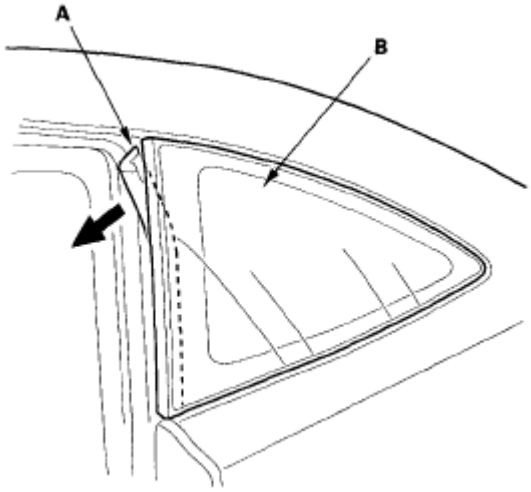

Fig. 54: Removing Front Seal From Front Edge Of Quarter Glass

4. Carefully cut through the adhesive (A) at the rear corner portion of the quarter glass (B) with a utility knife. With a helper on the outside, pull the piano wire (C) back and forth in a sawing motion. Hold the piano wire as close to the quarter glass as possible to prevent damage to the body, and carefully cut through the adhesive around the entire quarter glass:
    - If the quarter glass is to be reinstalled, take care not to damage the molding (D).
    - If the molding is damaged, replace the quarter glass, molding, and clips (E) as an assembly.
    - If any of the clips are broken, the quarter glass can be reinstalled using butyl tape (refer to step 11).

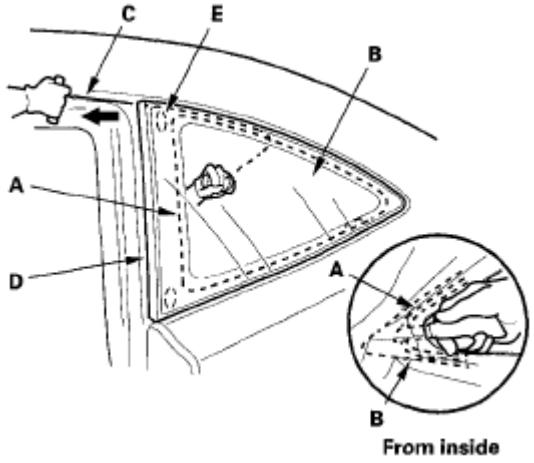

Fig. 55: Pulling Piano Wire Back And Forth In Sawing Motion

Cutting positions

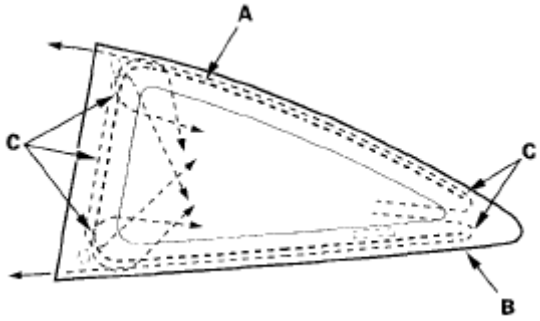

Fig. 56: Identifying Cutting Positions

5. Carefully remove the quarter glass.
6. With a putty knife, scrape the old adhesive smooth to a thickness of about 2 mm (0.08 in.) on the bonding surface around the entire quarter glass opening flange:
   - Do not scrape down to the painted surface of the body; damaged paint will interfere with proper bonding.
   - Remove the clips and fastener from the body.
7. Clean the body bonding surface with a sponge dampened in alcohol. After cleaning, keep oil, grease, and water from getting on the surface.
8. If the old quarter glass will be reinstalled, use a putty knife to scrape off the old adhesive, any broken clips, and the fastener from the glass. Clean the inside

face and the edge of the glass with alcohol where new adhesive will be applied. Make sure the bonding surface is kept free of water, oil, and grease.

9. Set the quarter glass in the opening. Make an alignment mark (A) to the quarter glass with a grease pencil as shown where the clip will be installed.

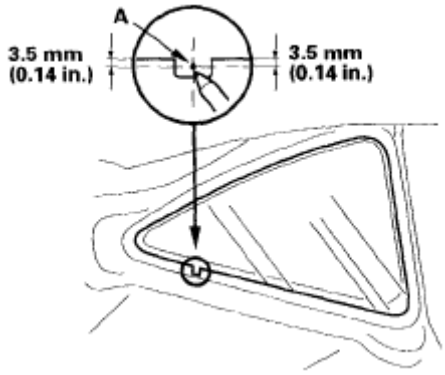

Fig. 57: Making Alignment Mark To Quarter Glass (With Specifications)

10. Remove the quarter glass.
11. If the old quarter glass will be reinstalled (and either clip is broken off the molding), apply a light coat of primer, then apply butyl tape (A) to the molding (B) as shown. Attach the clip (C) with adhesive tape to the inside face of the quarter glass (D):
    - Be sure the clip line up with alignment mark (E) you made in step 9.
    - Be careful not to touch the quarter glass where adhesive will be applied.
    - Do not peel the separator off the butyl tape.

Clip adhesive tape:

Thickness 0.4 mm (0.016 in.)
Width 7.5 mm (0.3 in.)

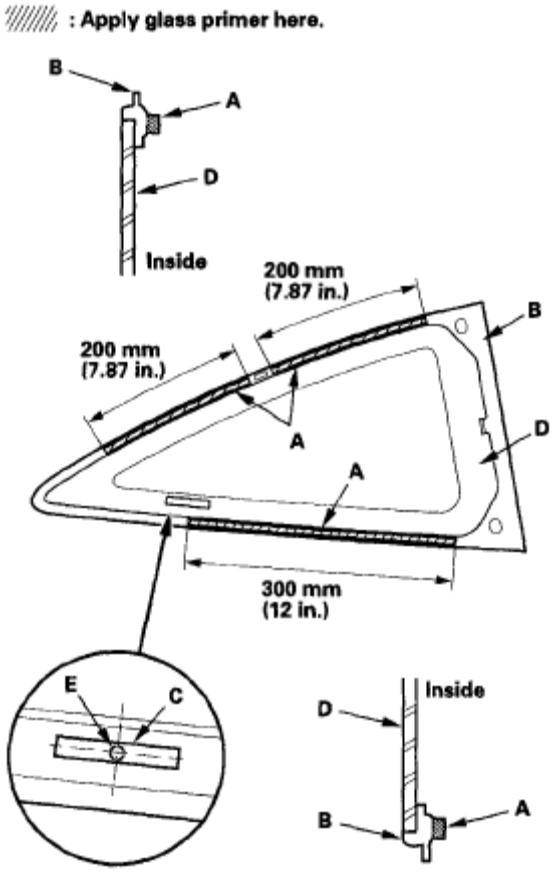

Fig. 58: Applying Butyl Tape To Molding (With Specifications)

12. Attach the front seal (A) with adhesive tape (B) onto the molding (C).

Seal adhesive tape:

Thickness 0.8 mm (0.031 in.)
Width 7 mm (0.28 in.)

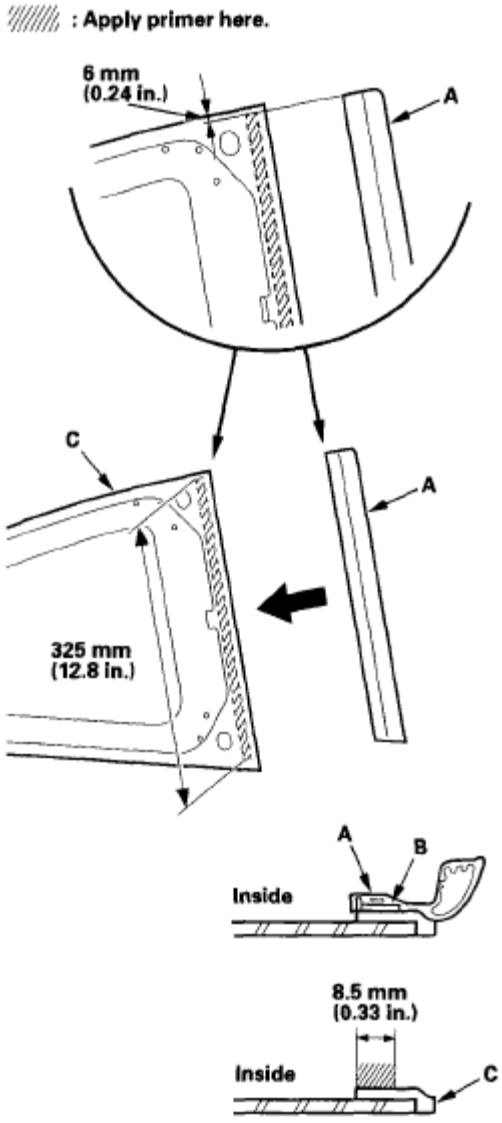

Fig. 59: Attaching Front Seal With Adhesive Tape Onto Molding (With Specifications)

13. If the old quarter glass will be reinstalled (and either clip is broken off the molding), seal the body holes with pieces of urethane tape (A). Then set the quarter glass upright in the opening, and make alignment marks (B) across the quarter glass and body with a grease pencil at the three points shown. Be careful not to touch the quarter glass where adhesive will be applied.

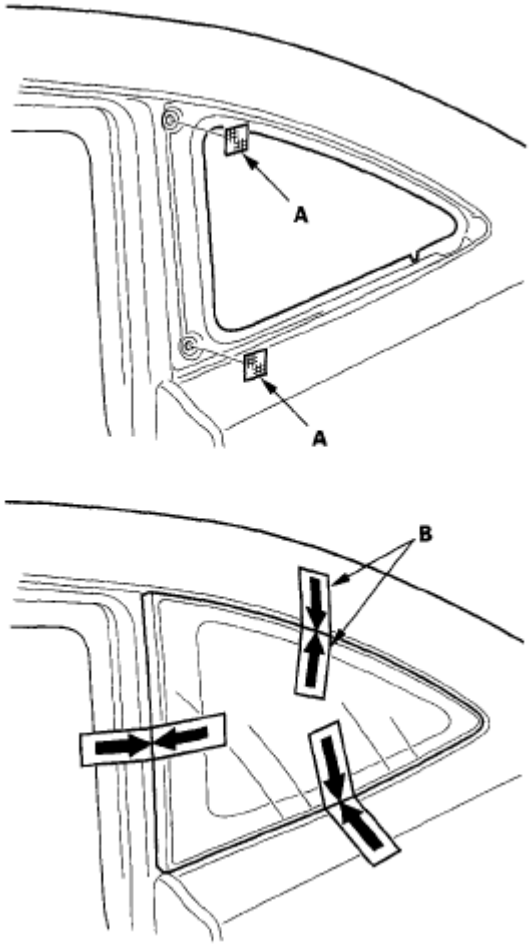

Fig. 60: Sealing Body Holes With Pieces Of Urethane Tape

14. Remove the quarter glass.
15. With a sponge, apply a light coat of glass primer along the edge of the front seal (A) and molding (B) as shown, then lightly wipe it off with gauze or cheesecloth:
    - With the printed dots (C) on the quarter glass (D) as a guide, apply the glass primer to the front portion of the quarter glass.
    - Do not apply body primer to the quarter glass, and do not get body and glass primer sponges mixed up.
    - Never touch the primed surfaces with your hands. If you do, the adhesive may not bond to the quarter glass properly, causing a leak after the quarter glass is installed.
    - Keep water, dust, and abrasive materials away from primed surfaces.

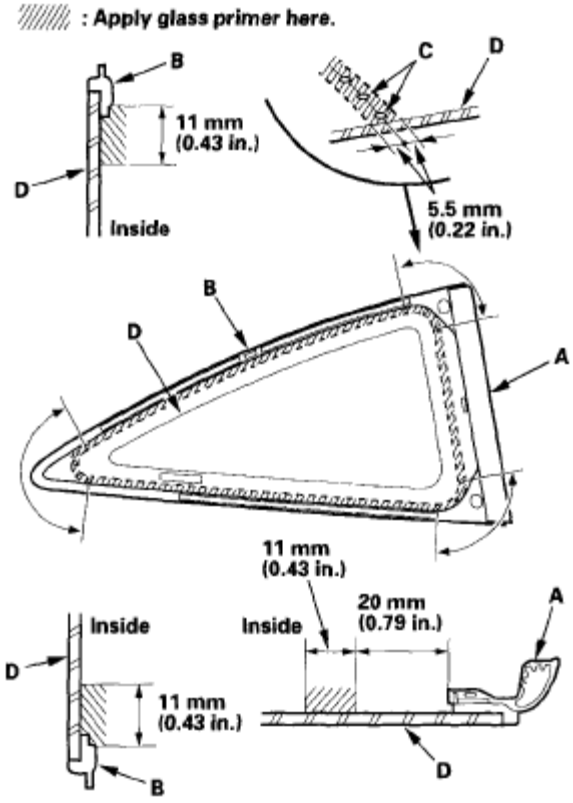

Fig. 61: Applying Glass Primer Along Edge Of Front Seal And Molding (With Specifications)

16. With a sponge, carefully apply a light coat of body primer to any exposed paint or metal around the flange where new adhesive will be applied. Let the primer dry for at least 10 minutes:
    - Do not apply body primer to any remaining original adhesive on the flange.
    - Be careful not to mix up the body and glass primer sponges.
    - Never touch the primed surfaces with your hands.

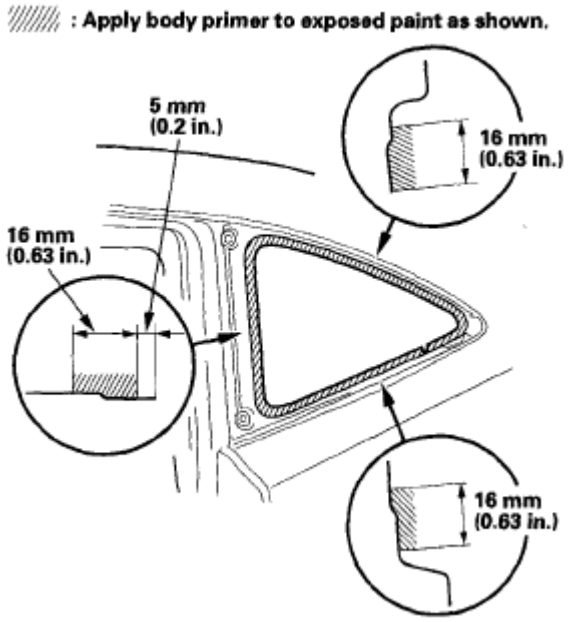

Fig. 62: Applying Body Primer To Any Exposed Paint (With Specifications)

17. Cut a "V" in the end of the nozzle (A) on the adhesive cartridge as shown.

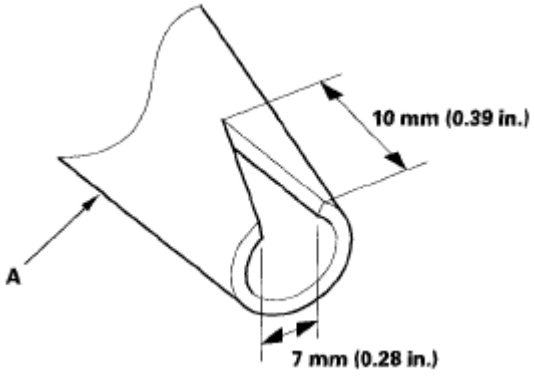

Fig. 63: Cutting "V" In End Of Nozzle (With Specifications)

18. Pack adhesive into the cartridge without air pockets to ensure continuous delivery. Put the cartridge in a caulking gun, and run a bead of adhesive (A) around the edge of the front seal (B) and molding (C) as shown. With the glass primer (D) you applied in step 15 on the quarter glass (E) as a guide, apply the adhesive to the upper and lower corner portions of the quarter glass. Apply the adhesive within 30 minutes after applying the glass primer. Make a slightly thicker bead at each corner.

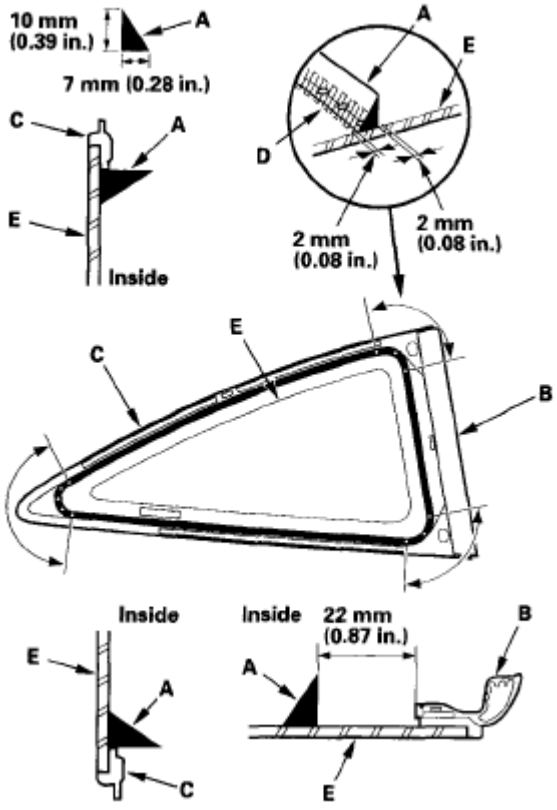

Fig. 64: Running Bead Of Adhesive Around Edge Of Front Seal And Molding (With Specifications)

19. Using suction cups (A) to hold the quarter glass (B) over the opening, align the clips or the alignment marks (C) made in step 13, and set it down on the adhesive. Lightly push on the quarter glass until its edges are fully seated on the adhesive all the way around.

NOTE: Do not open or close any of the doors for about an hour until the adhesive is dry.

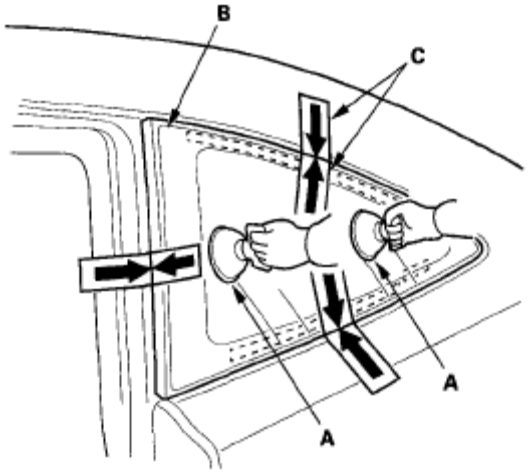

Fig. 65: Holding Quarter Glass Using Suction Cups

20. Scrape or wipe the excess adhesive off with a putty knife or towel. To remove adhesive from a painted surface or the quarter glass, wipe with a soft shop towel dampened with alcohol.
21. After the adhesive has dried, spray water over the quarter glass window and check for leaks. Mark the leaking areas, let the quarter glass window dry, then seal with sealant. Let the vehicle stand for at least 4 hours after quarter glass window installation. If the vehicle has to be used within the first 4 hours, it must be driven slowly.
22. Reinstall all remaining removed parts.

NOTE: Advise the customer not to do the following things for 2 to 3 days:

- **Slam the doors with all the windows rolled up.**
- **Twist the body excessively (such as when going in and out of driveways at an angle or driving over rough, uneven roads).**